

# *Grizzly* *Industrial, Inc.*®

## **MODEL G0704 MILL/DRILL WITH STAND OWNER'S MANUAL**



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE  
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**  
(FOR MODELS MANUFACTURED SINCE 09/09) #JB12468 PRINTED IN CHINA



## **WARNING!**

**This manual provides critical safety instructions on the proper setup, operation, maintenance, and service of this machine/tool. Save this document, refer to it often, and use it to instruct other operators.**

**Failure to read, understand and follow the instructions in this manual may result in fire or serious personal injury—including amputation, electrocution, or death.**

**The owner of this machine/tool is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, cutting/sanding/grinding tool integrity, and the usage of personal protective equipment.**

**The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.**



## **WARNING!**

**Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:**

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

**Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.**

# Table of Contents

<b>INTRODUCTION</b> .....	<b>2</b>	<b>SECTION 5: ACCESSORIES</b> .....	<b>33</b>
Manual Accuracy .....	2	<b>SECTION 6: MAINTENANCE</b> .....	<b>36</b>
Contact Info.....	2	Schedule .....	36
Machine Description .....	2	Lubrication .....	36
Identification.....	3	<b>SECTION 7: SERVICE</b> .....	<b>39</b>
Electronic Controls Identification .....	4	Troubleshooting .....	39
<b>SECTION 1: SAFETY</b> .....	<b>8</b>	Gibs.....	41
Safety Instructions for Machinery .....	8	Leadscrew Backlash.....	42
Additional Safety for Mill/Drills .....	10	Digital Readout Unit Battery Replacement ..	42
<b>SECTION 2: POWER SUPPLY</b> .....	<b>11</b>	Motor Service.....	43
<b>SECTION 3: SETUP</b> .....	<b>13</b>	<b>SECTION 8: WIRING</b> .....	<b>44</b>
Needed for Setup.....	13	Wiring Safety Instructions .....	44
Unpacking .....	13	Wiring Diagram .....	45
Inventory .....	14	Electrical Components .....	46
Cleanup.....	15	<b>SECTION 9: PARTS</b> .....	<b>47</b>
Site Considerations.....	16	Column Breakdown.....	47
Moving & Placing Machine .....	17	Column Parts List .....	48
Mounting to Shop Floor .....	18	Electrical Box Breakdown & Parts List .....	49
Assembly .....	19	Headstock Breakdown.....	50
Drill Chuck Arbor.....	19	Headstock Parts List.....	51
Power Connection.....	20	Chip Guard Breakdown & Parts List.....	52
Test Run & Spindle Break-in .....	21	Labels Breakdown & Parts List.....	53
<b>SECTION 4: OPERATIONS</b> .....	<b>22</b>	<b>WARRANTY AND RETURNS</b> .....	<b>57</b>
Basic Controls.....	22		
<b>SECTION 4: OPERATIONS</b> .....	<b>24</b>		
Operation Overview .....	24		
Digital Readout Unit.....	25		
Calculating Spindle Speed.....	26		
Spindle Speed and Direction .....	27		
Spindle Height Controls .....	28		
Drill Chuck.....	29		
Loading Tooling .....	30		
Headstock Travel (Z-Axis and Rotation).....	31		
Table Travel.....	32		


# INTRODUCTION

## Manual Accuracy

We are proud to offer this manual with your new machine! We've made every effort to be exact with the instructions, specifications, drawings, and photographs of the machine we used when writing this manual. However, sometimes we still make an occasional mistake.

Also, owing to our policy of continuous improvement, **your machine may not exactly match the manual**. If you find this to be the case, and the difference between the manual and machine leaves you in doubt, check our website for the latest manual update or call technical support for help.

Before calling, find the manufacture date of your machine by looking at the date stamped into the machine ID label (see below). This will help us determine if the manual version you received matches the manufacture date of your machine.

		MODEL GXXXX MACHINE NAME	
SPECIFICATIONS		▲ WARNING!	
Motor:		<b>Manufacture Date of Your Machine</b> When using this machine: 1. Always wear safety glasses and respirator. 2. Read and understand the manual before starting. 3. Make sure the workpiece is properly secured. 4. Make sure the motor has stopped and disconnect power before adjustments, maintenance, or service. 5. DO NOT expose to rain or dampness. 6. DO NOT modify this machine in any way. 7. DO NOT remove safety guards. 8. Never leave machine running unattended. 9. DO NOT operate under the influence of drugs or alcohol. 10. Maintain machine carefully to prevent accidents.	
Specification:			
Specification:			
Specification:			
Weight:			
<input type="text"/>	Date		
<input type="text"/>	Serial Number		
Manufactured for Grizzly in Taiwan			

For your convenience, we post all available manuals and manual updates for free on our website at [www.grizzly.com](http://www.grizzly.com). Any updates to your model of machine will be reflected in these documents as soon as they are complete.

## Contact Info

We stand behind our machines. If you have any questions or need help, use the information below to contact us. Before contacting, please get the serial number and manufacture date of your machine. This will help us help you faster.

Grizzly Technical Support  
1203 Lycoming Mall Circle  
Muncy, PA 17756  
Phone: (570) 546-9663  
Email: [techsupport@grizzly.com](mailto:techsupport@grizzly.com)

We want your feedback on this manual. What did you like about it? Where could it be improved? Please take a few minutes to give us feedback.

Grizzly Documentation Manager  
P.O. Box 2069  
Bellingham, WA 98227-2069  
Email: [manuals@grizzly.com](mailto:manuals@grizzly.com)

## Machine Description

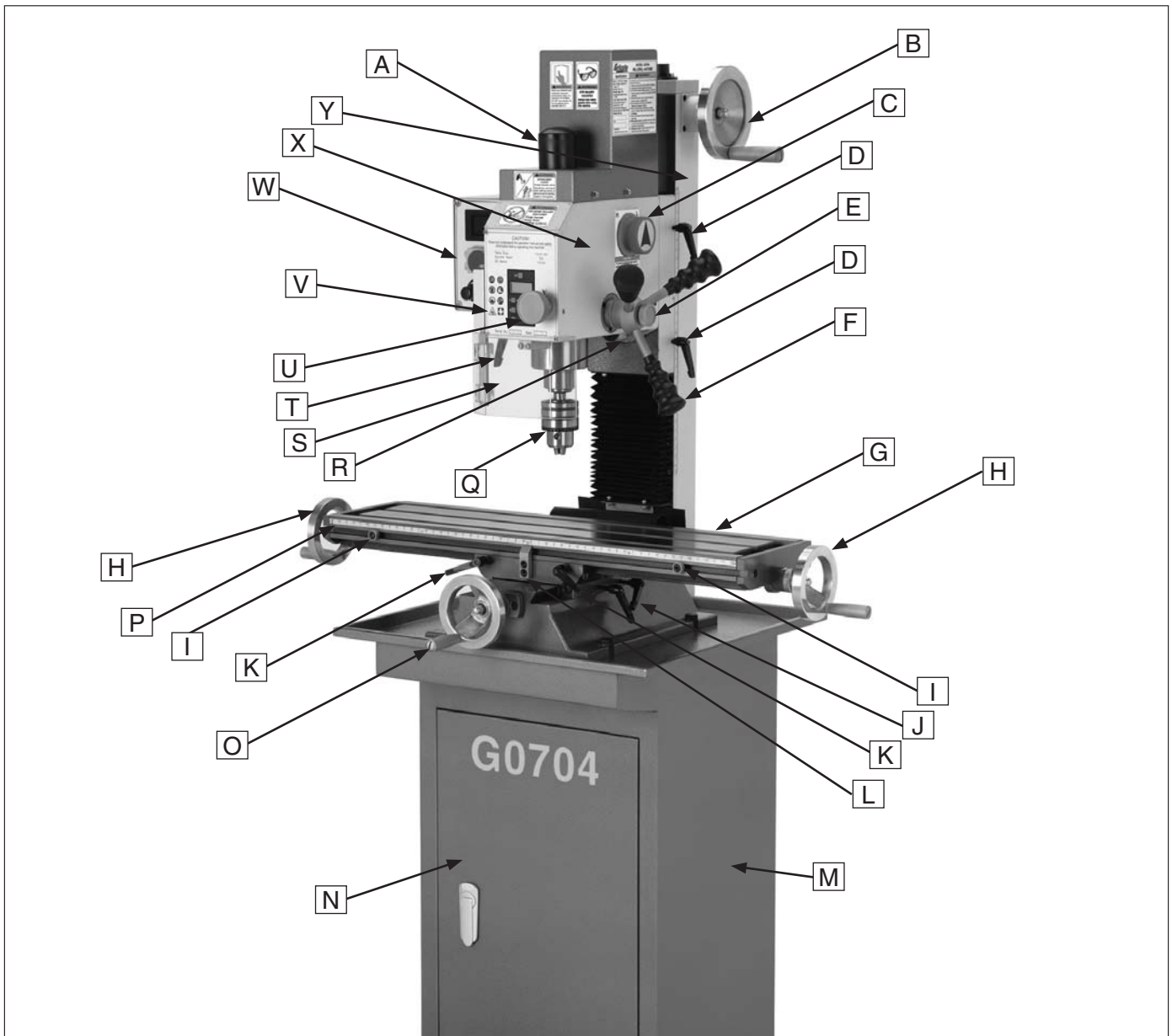
The mill/drill is used to shape metal and solid workpieces by removing material with the use of a rotating cutting tool.

In milling operations, the cutting tool remains stationary while the workpiece is drawn across it by moving the table.

In drilling operations, the workpiece is held stationary on the table while the cutting tool moves up-and-down with the movement of the spindle and head.



# Identification



**Figure 1.** G0704 Identification.

- |   |   |
|---|---|
| <b>A.</b> Drawbar Cap and Drawbar         | <b>N.</b> Storage Access Door               |
| <b>B.</b> Vertical (Z-Axis) Handwheel     | <b>O.</b> Cross (Y-Axis) Handwheel          |
| <b>C.</b> Speed Range Selector Knob       | <b>P.</b> Longitudinal Scale                |
| <b>D.</b> Vertical Travel Lock            | <b>Q.</b> Drill Chuck                       |
| <b>E.</b> Fine Feed Lock Knob             | <b>R.</b> Headstock Tilt Scale              |
| <b>F.</b> Quill Feed Lever                | <b>S.</b> Chip Guard                        |
| <b>G.</b> Table                           | <b>T.</b> Quill Lock Lever                  |
| <b>H.</b> Longitudinal (X-Axis) Handwheel | <b>U.</b> Fine Feed Knob                    |
| <b>I.</b> Longitudinal Table Stop         | <b>V.</b> Digital Readout ( <b>Page 4</b> ) |
| <b>J.</b> Table Cross Travel Locks        | <b>W.</b> Control Panel ( <b>Page 4</b> )   |
| <b>K.</b> Table Longitudinal Travel Lock  | <b>X.</b> Headstock                         |
| <b>L.</b> Table Center Stop               | <b>Y.</b> Column                            |
| <b>M.</b> Machine Stand                   |   |



# Electronic Controls Identification

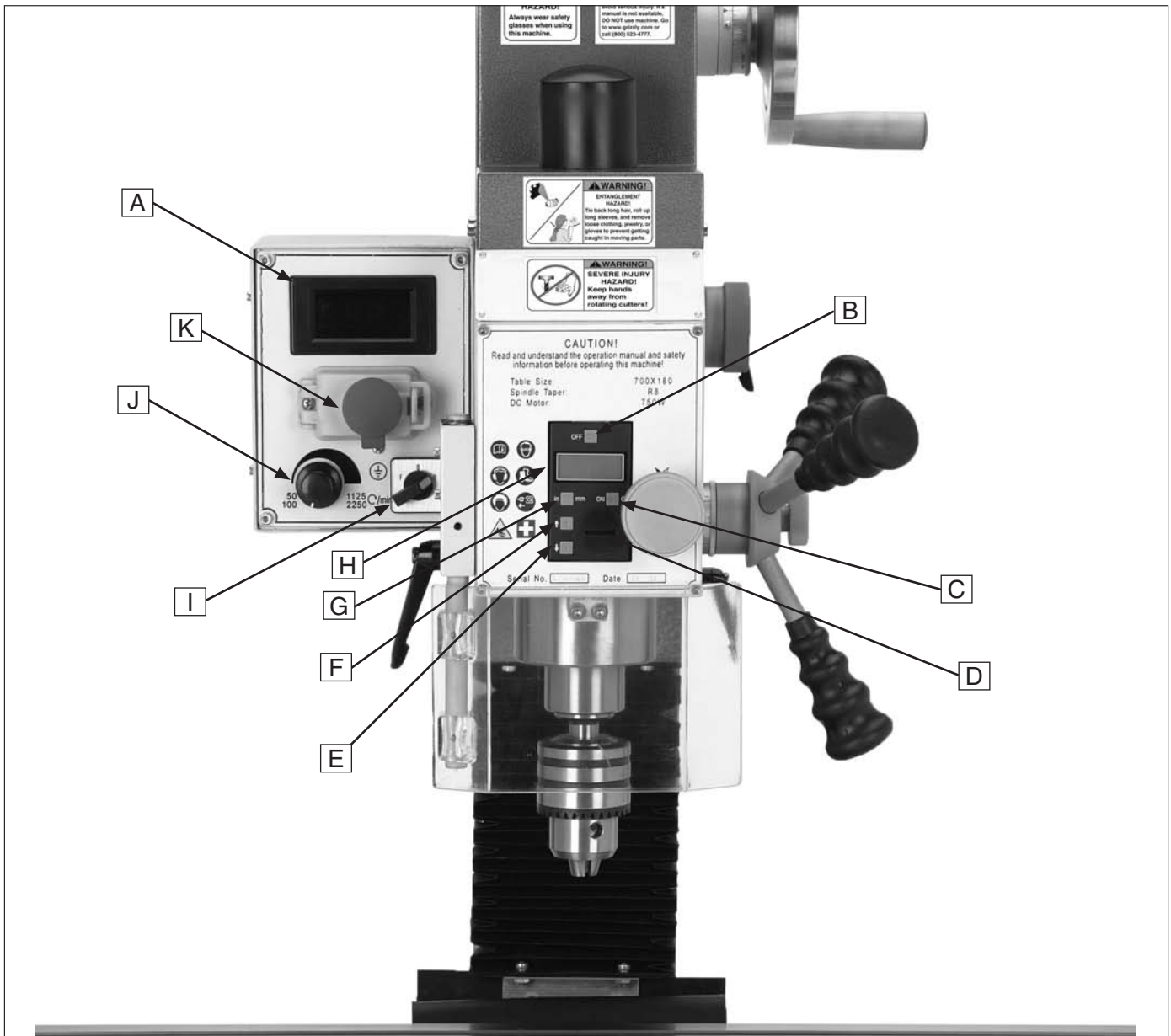


Figure 2. G0704 electronic controls identification.

- |   |  |
|---|--|
| <b>A.</b> Spindle RPM Readout                     | <b>G.</b> IN/MM Unit Selection Button      |
| <b>B.</b> Spindle Digital Readout OFF Button      | <b>H.</b> Spindle Depth Display            |
| <b>C.</b> Digital Readout ON/ZERO Button          | <b>I.</b> Spindle Direction Selection Knob |
| <b>D.</b> Digital Readout Battery Cover & Battery | <b>J.</b> Variable Spindle Speed Knob      |
| <b>E.</b> Spindle Depth Display DECREASE Button   | <b>K.</b> START/Emergency STOP Buttons     |
| <b>F.</b> Spindle Depth Display INCREASE Button   |  |





# MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

## MODEL G0704 DRILL/MILL WITH STAND

### Product Dimensions:

Weight..... 265 lbs.  
Width (side-to-side) x Depth (front-to-back) x Height..... 38 x 24 x 31 in.  
Footprint (Length x Width)..... 13-3/8 x 16-1/2 in.

### Shipping Dimensions:

#### Carton #1

Type..... Plywood  
Content..... Machine  
Weight..... 309 lbs.  
Length x Width x Height..... 28 x 30 x 35 in.

#### Carton #2

Type..... Cardboard  
Content..... Stand  
Weight..... 77 lbs.  
Length x Width x Height..... 18 x 15 x 33 in.

### Electrical:

Power Requirement..... 110V, Single-Phase, 60 Hz  
Minimum Circuit Size..... 15 Amp  
Switch..... ON/OFF Buttons with Lockout Cover  
Switch Voltage..... 110V  
Cord Length..... 6 ft.  
Cord Gauge..... 18 gauge  
Plug Included..... Yes  
Included Plug Type..... NEMA 5-15

### Motors:

#### Main

Type..... Universal  
Horsepower..... 1 HP  
Voltage..... 110V  
Phase..... Single-Phase  
Amps..... 3.2A  
Speed..... 5000 RPM  
Cycle..... 60 Hz  
Number of Speeds..... 1  
Power Transfer ..... Gear Drive  
Bearings..... Shielded and Permanently Sealed



**Main Specifications:**

**Operation Info**

Spindle Travel.....	2 in.
Longitudinal Table Travel.....	18-7/8 in.
Cross Table Travel.....	6-7/8 in.
Head Travel.....	11 in.
Head Swivel (Left-to-Right).....	+/- 90 deg.
Maximum Distance Spindle to Column.....	7-1/2 in.
Maximum Distance Spindle to Table.....	13 in.
Drilling Capacity for Cast Iron.....	3/4 in.
Drilling Capacity for Steel.....	5/8 in.
Number of Vertical Spindle Speeds.....	2 Variable Ranges
Range of Vertical Spindle Speeds.....	50-2250 RPM

**Table Info**

Table Length.....	26-5/8 in.
Table Width.....	7-1/16 in.
Table Thickness.....	1-3/4 in.
Number of T-Slots.....	3
T-Slots Width.....	1/2 in.
T-Slots Height.....	5/8 in.
T-Slots Centers.....	2-1/2 in.
Stud Size.....	3/8 in.

**Spindle Info**

Spindle Taper.....	R-8
Spindle Sleeve Diameter.....	2.36 in.
End Milling Capacity.....	3/4 in.
Face Milling Capacity.....	2-1/2 in.
Drawbar Diameter.....	7/16 in.
Drawbar TPI.....	20
Drawbar Length.....	9-11/16 in.
Spindle Bearings.....	Tapered Roller

**Construction**

Spindle Housing/Quill.....	Cast Iron
Table.....	Precision-Ground Cast Iron
Head.....	Cast Iron
Column.....	Cast Iron
Base.....	Cast Iron
Stand.....	Steel
Paint.....	Epoxy

**Other**

Collar Graduations.....	0.002 in.
-------------------------	-----------





**Features:**

- Digital spindle scale reads metric, inches, zero, set, on/off
- Forward/reverse switch
- Chip guard
- Digital display for spindle speed
- Dovetail column
- Front mounted fine feed knob
- Coolant trough

**Accessories Included:**

- Drill chuck 1/16-1/2 in. with B16 taper
- Drill chuck arbor B16 x R8
- Two T-bolts
- Two open-ended combo wrenches
- Chuck key
- Oil bottle
- Extra fuse
- Hex wrenches
- Standard and Phillips screwdrivers
- Tool box



# SECTION 1: SAFETY

## **WARNING**

### **For Your Own Safety, Read Instruction Manual Before Operating this Machine**

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

### ***NOTICE***

This symbol is used to alert the user to useful information about proper operation of the machine.

## **WARNING**

### **Safety Instructions for Machinery**

**OWNER'S MANUAL.** Read and understand this owner's manual **BEFORE** using machine. Untrained users can be seriously hurt.

**EYE PROTECTION.** Always wear ANSI-approved safety glasses or a face shield when operating or observing machinery to reduce the risk of eye injury or blindness from flying particles. Everyday eyeglasses are not approved safety glasses.

**HAZARDOUS DUST.** Dust created while using machinery may cause cancer, birth defects, or long-term respiratory damage. Be aware of dust hazards associated with each workpiece material, and always wear a NIOSH-approved respirator to reduce your risk.

**WEARING PROPER APPAREL.** Do not wear clothing, apparel, or jewelry that can become entangled in moving parts. Always tie back or cover long hair. Wear non-slip footwear to avoid accidental slips which could cause a loss of workpiece control.

**HEARING PROTECTION.** Always wear hearing protection when operating or observing loud machinery. Extended exposure to this noise without hearing protection can cause permanent hearing loss.

**MENTAL ALERTNESS.** Be mentally alert when running machinery. Never operate under the influence of drugs or alcohol, when tired, or when distracted.



# WARNING

**DISCONNECTING POWER SUPPLY.** Always disconnect machine from power supply before servicing, adjusting, or changing cutting tools (bits, blades, cutters, etc.). Make sure switch is in OFF position before reconnecting to avoid an unexpected or unintentional start.

**APPROVED OPERATION.** Untrained operators can be seriously hurt by machinery. Only allow trained or properly supervised people to use machine. When machine is not being used, disconnect power, remove switch keys, or lock-out machine to prevent unauthorized use—especially around children. Make workshop kid proof!

**DANGEROUS ENVIRONMENTS.** Do not use machinery in wet or rainy locations, cluttered areas, around flammables, or in poorly-lit areas. Keep work area clean, dry, and well-lighted to minimize risk of injury.

**ONLY USE AS INTENDED.** Only use machine for its intended purpose. Never modify or alter machine for a purpose not intended by the manufacturer or serious injury may result!

**USE RECOMMENDED ACCESSORIES.** Consult this owner's manual or the manufacturer for recommended accessories. Using improper accessories will increase the risk of serious injury.

**CHILDREN & BYSTANDERS.** Keep children and bystanders a safe distance away from work area. Stop using machine if children or bystanders become a distraction.

**REMOVE ADJUSTING TOOLS.** Never leave adjustment tools, chuck keys, wrenches, etc. in or on machine—especially near moving parts. Verify removal before starting!

**SECURING WORKPIECE.** When required, use clamps or vises to secure workpiece. A secured workpiece protects hands and frees both of them to operate the machine.

**FEED DIRECTION.** Unless otherwise noted, feed work against the rotation of blades or cutters. Feeding in the same direction of rotation may pull your hand into the cut.

**FORCING MACHINERY.** Do not force machine. It will do the job safer and better at the rate for which it was designed.

**GUARDS & COVERS.** Guards and covers can protect you from accidental contact with moving parts or flying debris. Make sure they are properly installed, undamaged, and working correctly before using machine.

**NEVER STAND ON MACHINE.** Serious injury or accidental contact with cutting tool may occur if machine is tipped. Machine may be damaged.

**STABLE MACHINE.** Unexpected movement during operations greatly increases the risk of injury and loss of control. Verify machines are stable/secure and mobile bases (if used) are locked before starting.

**AWKWARD POSITIONS.** Keep proper footing and balance at all times when operating machine. Do not overreach! Avoid awkward hand positions that make workpiece control difficult or increase the risk of accidental injury.

**UNATTENDED OPERATION.** Never leave machine running while unattended. Turn machine **OFF** and ensure all moving parts completely stop before walking away.

**MAINTAIN WITH CARE.** Follow all maintenance instructions and lubrication schedules to keep machine in good working condition. An improperly maintained machine may increase the risk of serious injury.

**CHECK DAMAGED PARTS.** Regularly inspect machine for damaged parts, loose bolts, mis-adjusted or mis-aligned parts, binding, or any other conditions that may affect safe operation. Always repair or replace damaged or mis-adjusted parts before operating machine.

**EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support Department at (570) 546-9663.



# **WARNING**

## **Additional Safety for Mill/Drills**

**UNDERSTANDING CONTROLS.** Make sure you understand the use and operation of all controls.

**SAFETY ACCESSORIES.** Always use a chip guard in addition to your safety glasses when milling/drilling to prevent bodily injury.

**WORK HOLDING.** Before starting the machine, be certain the workpiece has been properly clamped to the table. NEVER hold the workpiece by hand when using the mill/drill.

**CHUCK KEY SAFETY.** Always remove your chuck key, drawbar wrench, and any service tools immediately after use.

**SPINDLE SPEEDS.** Select the spindle speed that is appropriate for the type of work and material. Allow the mill/drill to gain full speed before beginning a cut.

**POWER DISRUPTION.** In the event of a local power outage during use of the mill, drill turn **OFF** all switches to avoid possible sudden start up once power is restored.

**SPINDLE DIRECTION CHANGES.** Never reverse spindle direction while the spindle is turning.

**MACHINE CARE AND MAINTENANCE.** Never operate the mill/drill with damaged or worn parts. Maintain your mill/drill in proper working condition. Perform routine inspections and maintenance promptly. Put away adjustment tools after use.

**STOPPING SPINDLE.** DO NOT stop the mill/drill using your hand against the chuck.

**BE ATTENTIVE.** DO NOT leave the mill/drill running unattended for any reason.

**DISCONNECT POWER.** Make sure the mill/drill is turned **OFF**, disconnected from its power source and all moving parts have come to a complete stop before starting any inspection, adjustment, or maintenance procedure.

**AVOIDING ENTANGLEMENT.** Keep loose clothing articles such as sleeves, belts or jewelry items away from the spindle. Never wear gloves when operating the mill/drill.

**TOOL HOLDING.** Always use the proper tools for the material you are machining. Make sure they are held firmly in the proper tool holder for the job.

**CLEAN-UP.** DO NOT clear chips by hand. Use a brush, and never clear chips while the spindle is turning.

**CUTTING TOOL INSPECTION.** Inspect drills and end mills for sharpness, chips, or cracks before each use. Replace dull, chipped, or cracked cutting tools immediately. Handle new cutting tools with care. Leading edges are very sharp and can cause lacerations.

**EXPERIENCING DIFFICULTIES.** If at any time you are experiencing difficulties performing the intended operation, stop using the machine! Contact our Technical Support at (570) 546-9663.

# **WARNING**

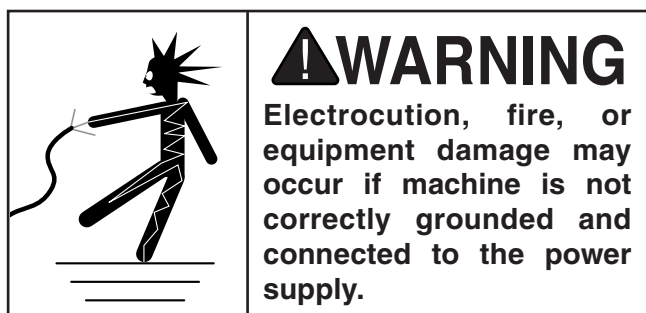
No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G0704. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



# SECTION 2: POWER SUPPLY

## Availability

Before installing the machine, consider the availability and proximity of the required power supply circuit. If an existing circuit does not meet the requirements for this machine, a new circuit must be installed. To minimize the risk of electrocution, fire, or equipment damage, installation work and electrical wiring must be done by a qualified electrician in accordance with all applicable codes and standards.



## Full-Load Current Rating

The full-load current rating is the amperage a machine draws at 100% of the rated output power. On machines with multiple motors, this is the amperage drawn by the largest motor or sum of all motors and electrical devices that might operate at one time during normal operations.

### Full-Load Current Rating at 110V..... 3.2 Amps

The full-load current is not the maximum amount of amps that the machine will draw. If the machine is overloaded, it will draw additional amps beyond the full-load rating.

If the machine is overloaded for a sufficient length of time, damage, overheating, or fire may result—especially if connected to an undersized circuit. To reduce the risk of these hazards, avoid overloading the machine during operation and make sure it is connected to a power supply circuit that meets the requirements in the following section.

## Circuit Requirements

This machine is prewired to operate on a 110V power supply circuit that has a verified ground and meets the following requirements:

**Nominal Voltage ..... 110V/120V**  
**Cycle.....60 Hz**  
**Phase..... Single-Phase**  
**Power Supply Circuit ..... 15 Amps**

A power supply circuit includes all electrical equipment between the breaker box or fuse panel in the building and the machine. The power supply circuit used for this machine must be sized to safely handle the full-load current drawn from the machine for an extended period of time. (If this machine is connected to a circuit protected by fuses, use a time delay fuse marked D.)



**Note:** *The circuit requirements listed in this manual apply to a dedicated circuit—where only one machine will be running at a time. If this machine will be connected to a shared circuit where multiple machines will be running at the same time, consult a qualified electrician to ensure that the circuit is properly sized for safe operation.*



## Grounding & Plug Requirements

This machine **MUST** be grounded. In the event of certain malfunctions or breakdowns, grounding reduces the risk of electric shock by providing a path of least resistance for electric current.

This machine is equipped with a power cord that has an equipment-grounding wire and a grounding plug (similar to the figure below). The plug must only be inserted into a matching receptacle (outlet) that is properly installed and grounded in accordance with all local codes and ordinances.

**⚠ WARNING**

**Serious injury could occur if you connect the machine to power before completing the setup process. DO NOT connect to power until instructed later in this manual.**

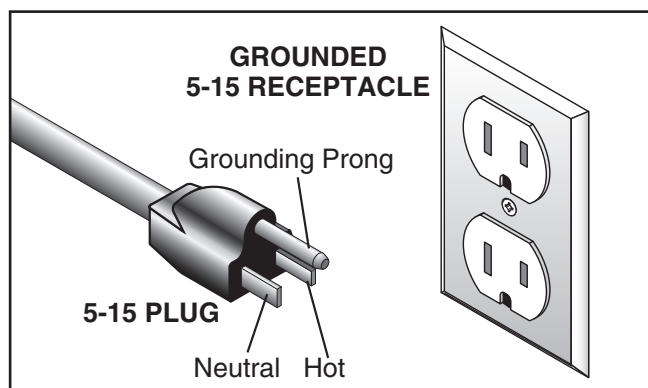


Figure 3. Typical 5-15 plug and receptacle.

**⚠ CAUTION**

**SHOCK HAZARD!**

**Two-prong outlets do not meet the grounding requirements for this machine. Do not modify or use an adapter on the plug provided—if it will not fit the outlet, have a qualified electrician install the proper outlet with a verified ground.**

Improper connection of the equipment-grounding wire can result in a risk of electric shock. The wire with green insulation (with or without yellow stripes) is the equipment-grounding wire. If repair or replacement of the power cord or plug is necessary, do not connect the equipment-grounding wire to a live (current carrying) terminal.

Check with a qualified electrician or service personnel if you do not understand these grounding requirements, or if you are in doubt about whether the tool is properly grounded. If you ever notice that a cord or plug is damaged or worn, disconnect it from power, and immediately replace it with a new one.

## Extension Cords

We do not recommend using an extension cord with this machine. If you must use an extension cord, only use it if absolutely necessary and only on a temporary basis.

Extension cords cause voltage drop, which may damage electrical components and shorten motor life. Voltage drop increases as the extension cord size gets longer and the gauge size gets smaller (higher gauge numbers indicate smaller sizes).

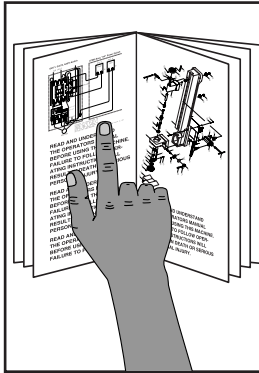
Any extension cord used with this machine must contain a ground wire, match the required plug and receptacle, and meet the following requirements:

- Minimum Gauge Size .....16 AWG**
- Maximum Length (Shorter is Better).....50 ft.**



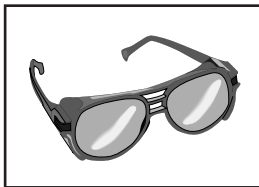


# SECTION 3: SETUP



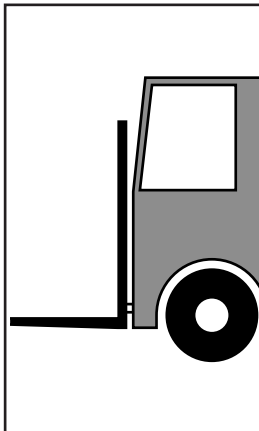
## **!WARNING**

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



## **!WARNING**

Wear safety glasses during the entire set up process!



## **!WARNING**

The Model G0704 is a heavy machine. Serious personal injury may occur if safe moving methods are not used. To be safe, get assistance and use power equipment to move the shipping crate and remove the machine from the crate.

## Needed for Setup

The following are needed to complete the setup process, but are not included with your machine:

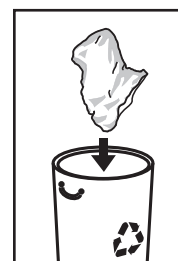
Description	Qty
• Precision Level .....	1
• Safety Glasses (for each person).....	1
• Standard Screwdriver #3.....	1
• Solvent/Cleaner .....	1
• Shop Rags.....	1
• Metal Shim Stock .....	1
• Brass Hammer .....	1
• Lifting Strap (Rated for at least 500 lbs.)....	1
• Lifting Equipment (Rated for at least 500 lbs.).....	1
• An Assistant .....	1

## Unpacking

Your machine was carefully packaged for safe transportation. Remove the packaging materials from around your machine and inspect it. If you discover any damage, *please call us immediately at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, inventory the contents.



## **!WARNING**

### **SUFFOCATION HAZARD!**

Keep children and pets away from plastic bags or packing materials unpacked with this machine. Discard immediately.



# Inventory

The following is a description of the main components shipped with your machine. Lay the components out to inventory them.

If any non-proprietary parts are missing (e.g. a nut or a washer), we will gladly replace them; or for the sake of expediency, replacements can be obtained at your local hardware store.

<b>Contents</b>	<b>Qty</b>
A. Mill/Drill w/Stand.....	1
B. Open End Combo Wrench 17/19.....	1
C. Open End Combo Wrench 8/10 .....	1
D. Bottle for Oil .....	1
E. Tool Box.....	1
F. Large Handwheel Handle.....	1
G. Small Handwheel Handles .....	3
H. T-Bolts M10-1.5 x 60 (vise mounting) .....	2
Flat Washers 10mm (vise mounting).....	2
Hex Nuts M10-1.5 (vise mounting).....	2
I. Drill Chuck .....	1
J. Chuck Key .....	1
K. Phillips Screwdriver .....	1
L. Flat Screwdriver.....	1
M. Arbor B16 x R8.....	1
N. Hex Wrench Set 2, 3, 4, 5, & 6mm .....	1 ea.

**Not Shown:**

Hex Bolts M10-1.5 x 50 .....	4
Flat Washers 10mm .....	4



Figure 4. G0704 out of the crate.

## **NOTICE**

**If you cannot find an item on this list, check the mounting location on the machine or the packaging materials. Sometimes parts are pre-installed for shipping, or they become hidden by packaging materials.**





# Cleanup

---

The unpainted surfaces of your machine are coated with a heavy-duty rust preventative that prevents corrosion during shipment and storage. This rust preventative works extremely well, but it will take a little time to clean.

Be patient and do a thorough job cleaning your machine. The time you spend doing this now will give you a better appreciation for the proper care of your machine's unpainted surfaces.

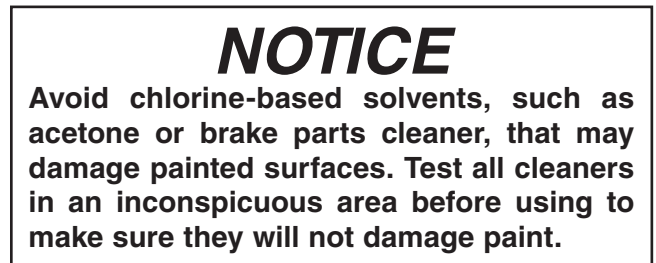
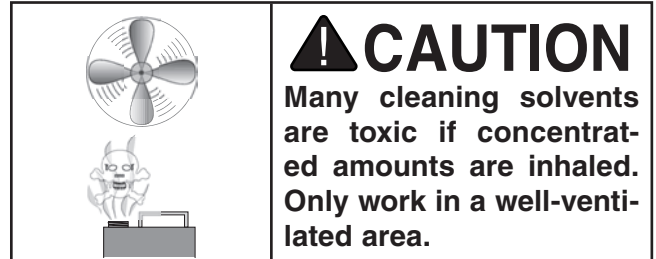
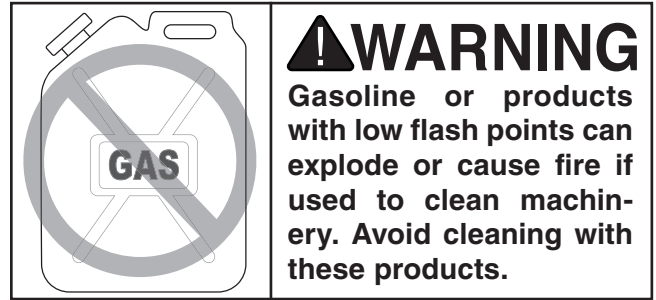
There are many ways to remove this rust preventative, but the following steps work well in a wide variety of situations. Always follow the manufacturer's instructions with any cleaning product you use and make sure you work in a well-ventilated area to minimize exposure to toxic fumes.

## Before cleaning, gather the following:

- Disposable Rags
- Cleaner/degreaser (WD•40 works well)
- Safety glasses & disposable gloves
- Plastic paint scraper (optional)

## Basic steps for removing rust preventative:

1. Put on safety glasses.
2. Coat the rust preventative with a liberal amount of cleaner/degreaser, then let it soak for 5–10 minutes.
3. Wipe off the surfaces. If your cleaner/degreaser is effective, the rust preventative will wipe off easily. If you have a plastic paint scraper, scrape off as much as you can first, then wipe off the rest with the rag.
4. Repeat **Steps 2–3** as necessary until clean, then coat all unpainted surfaces with a quality metal protectant to prevent rust.



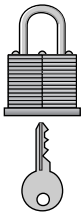
# Site Considerations

## Weight Load

Refer to the **Machine Data Sheet** for the weight of your machine. Make sure that the surface upon which the machine is placed will bear the weight of the machine, additional equipment that may be installed on the machine, and the heaviest workpiece that will be used. Additionally, consider the weight of the operator and any dynamic loading that may occur when operating the machine.

## Space Allocation

Consider the largest size of workpiece that will be processed through this machine and provide enough space around the machine for adequate operator material handling or the installation of auxiliary equipment. With permanent installations, leave enough space around the machine to open or remove doors/covers as required by the maintenance and service described in this manual. **See below for required space allocation.**



## CAUTION

Children or untrained people may be seriously injured by this machine. Only install in an access restricted location.

## Physical Environment

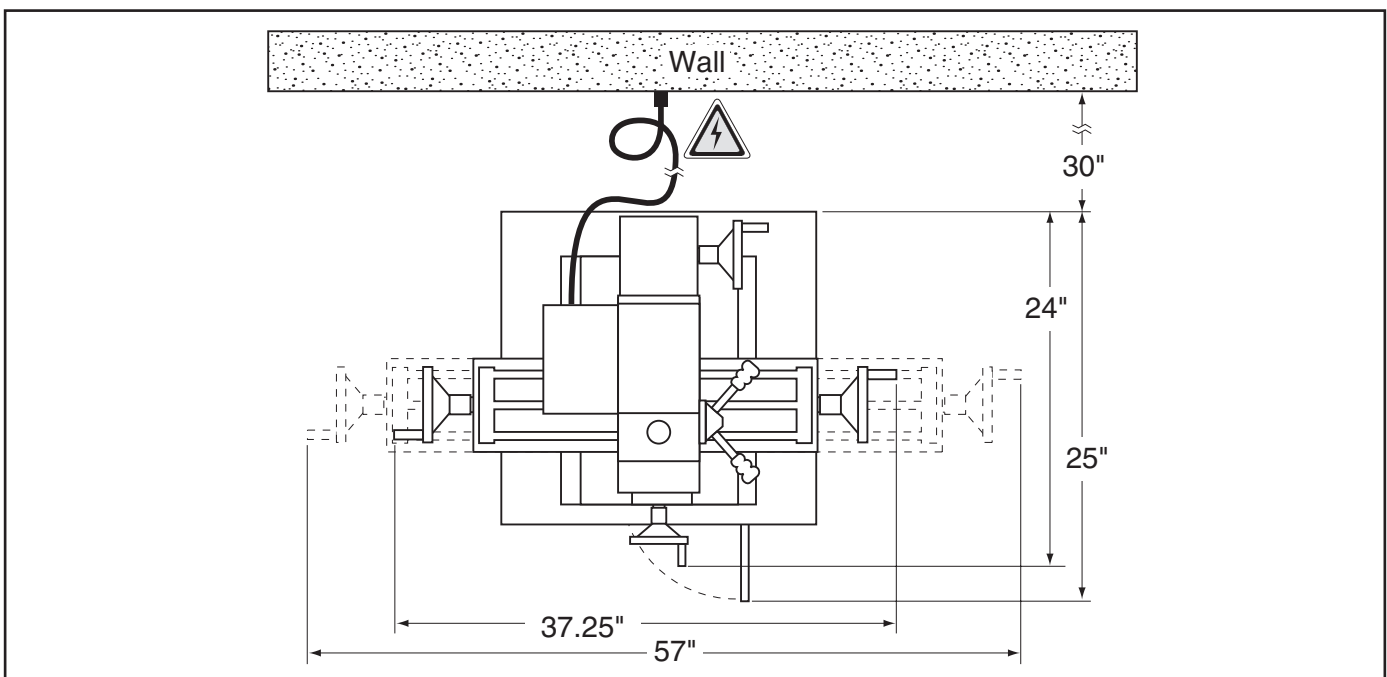
The physical environment where your machine is operated is important for safe operation and the longevity of its components. For best results, operate this machine in a dry environment that is free from excessive moisture, hazardous chemicals, airborne abrasives, or extreme conditions. Extreme conditions for this type of machinery are generally those where the ambient temperature range exceeds 41°–104°F; the relative humidity range exceeds 20–95% (non-condensing); or the environment is subject to vibration, shocks, or bumps.

## Electrical Installation

Place this machine near an existing power source. Make sure all power cords are protected from traffic, material handling, moisture, chemicals, or other hazards. Make sure to leave access to a means of disconnecting the power source or engaging a lockout/tagout device.

## Lighting

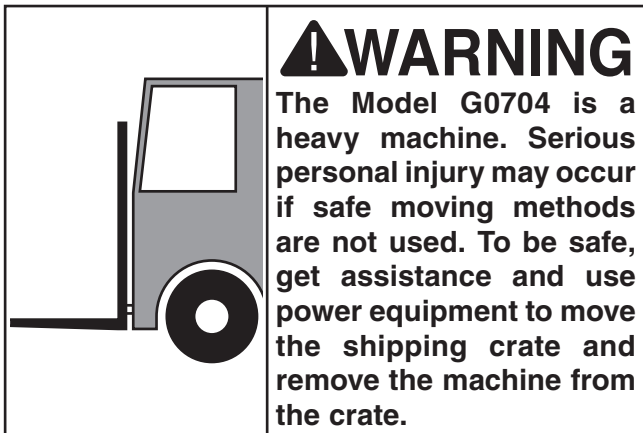
Lighting around the machine must be adequate enough that operations can be performed safely. Shadows, glare, or strobe effects that may distract or impede the operator must be eliminated.



**Figure 5.** Space required for full machine range of motion.

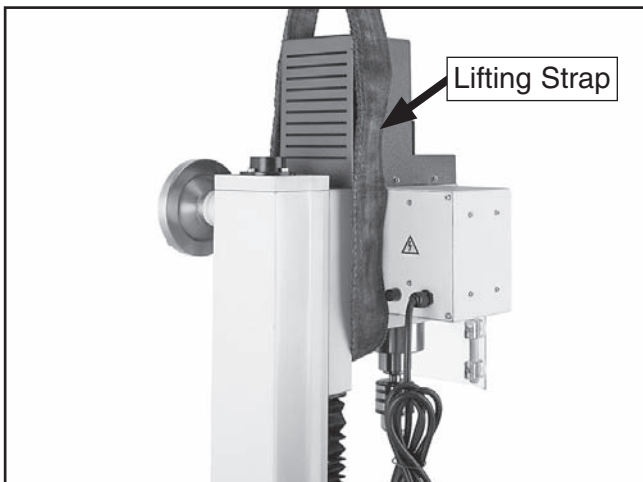


# Moving & Placing Machine



To remove your machine from the shipping crate and place it in position:

1. Place the crate adjacent to the location where your machine will be placed, then remove the shipping crate from the pallet.
2. Position the stand into the desired location.
3. Use the vertical handwheel to raise the headstock as far as possible.
4. Hang a lifting strap from the fork of a forklift and place it under the head of the mill/drill, as shown in **Figure 6**. Take care not to place the straps over any controls that may be damaged during transit.

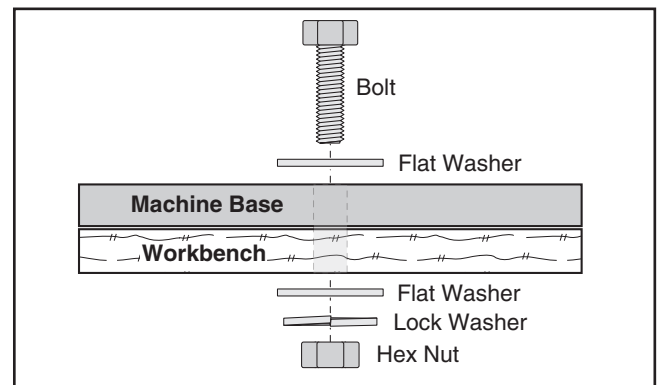


**Figure 6.** Lifting strap.

5. Unbolt the machine from the pallet, then with an assistant steadying the machine to prevent it from swinging, lift it slightly off of the pallet. Use the cross handwheel to move the table forward or backward as necessary to balance the machine so it hangs as close to level as possible.
6. Lift the machine and carefully place it onto the stand.
7. Bolt the machine to the stand with the four M10-1.25 x 50 hex bolts and flat washers.

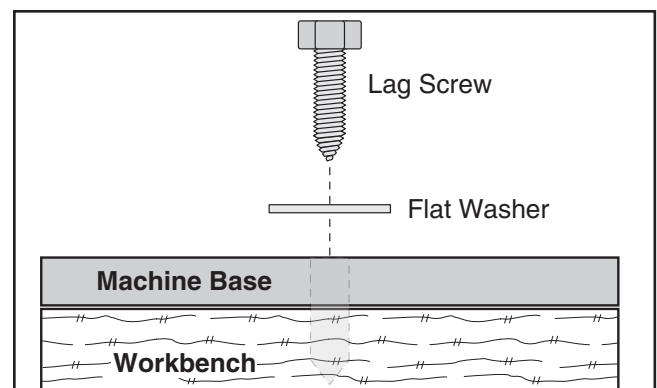
—If you are placing the machine on a workbench, it must be securely mounted to the workbench surface.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the machine to the workbench.



**Figure 7.** Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.



**Figure 8.** Example of a direct mount setup.



# Mounting to Shop Floor

Although not required, we recommend that you mount your new machine cabinet to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included. Generally, you can either bolt the cabinet to the floor or mount it on machine mounts. Both options are described below. Whichever option you choose, it is necessary to level the cabinet with a precision level.

## Bolting to Concrete Floors

Lag shield anchors with lag bolts and anchor studs (**Figure 9**) are two popular methods for anchoring an object to a concrete floor. We suggest you research the many options and methods for mounting your machine and choose the best that fits your specific application.



**Figure 9.** Typical fasteners for mounting to concrete floors.

## **NOTICE**

**Anchor studs are stronger and more permanent alternatives to lag shield anchors; however, they will stick out of the floor, which may cause a tripping hazard if you decide to move your machine.**

## Using Machine Mounts

Using machine mounts, shown in **Figure 10**, gives the advantage of fast leveling and vibration reduction. The large size of the foot pads distributes the weight of the machine to reduce strain on the floor.



**Figure 10.** Machine mount example.

## **NOTICE**

**We strongly recommend securing your machine to the floor if it is hardwired to the power source. Consult with your electrician to ensure compliance with local codes.**

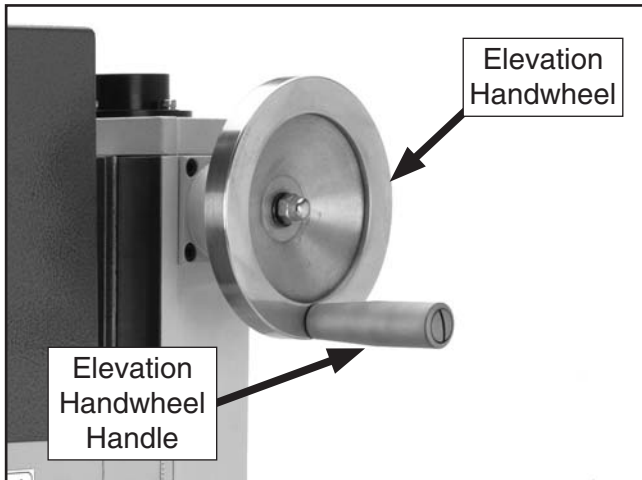


# Assembly

Assembly of the Model G0704 consists of attaching the four handwheel handles to the machine.

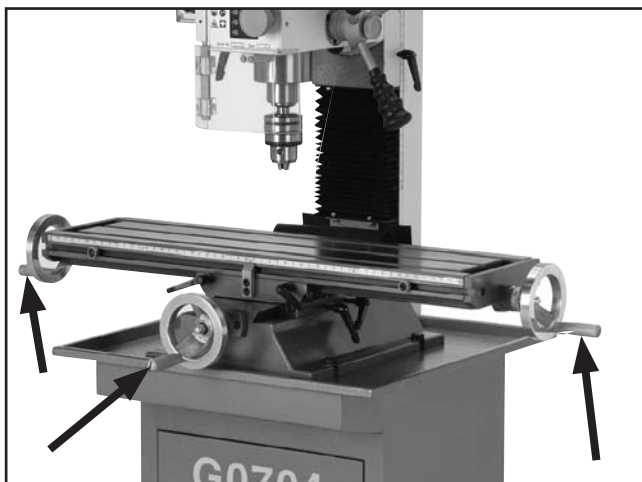
## To assemble your machine:

1. With a #3 standard screwdriver, install the large handwheel handle on the elevation handwheel (**Figure 11**).



**Figure 11.** Elevation handwheel handle.

2. Use the same method to install the three small handwheel handles to the three table travel handwheels (**Figure 12**).



**Figure 12.** Table handwheel handles.

# Drill Chuck Arbor

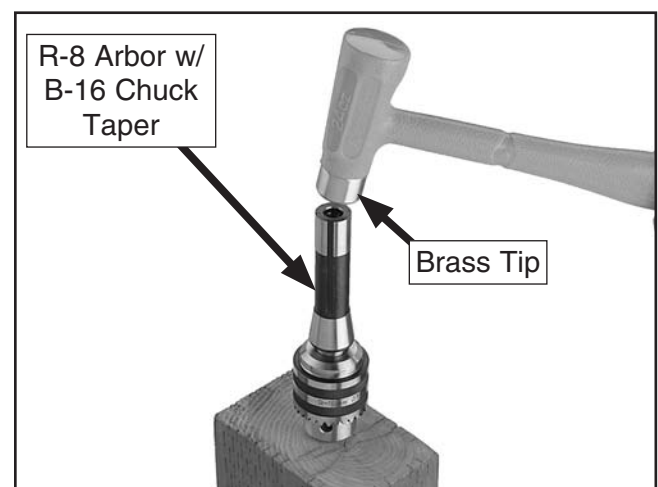
Your machine includes an B-16 drill chuck arbor and drill chuck. Before use, the drill chuck must be installed onto the arbor. The This drill chuck installation is intended to be semi-permanent.

**Tip:** For a permanent installation, chill the arbor in the freezer for 15 minutes before performing the following procedure. The taper will expand as it returns to room temperature, permanently locking the chuck.

## To install the drill chuck onto the arbor:

1. Clean the grease off the drill chuck and all taper mating surfaces. Pay particular attention to the B-16 bore in the drill chuck—it must be free from all grease, oil, and debris.
2. Retract the drill chuck jaws fully by turning the body of the drill chuck counterclockwise.
3. Insert the arbor into the drill chuck. Tap the arbor lightly with a brass or other soft-headed hammer to get a good fit.

**Note:** While it may not seem like there is anything keeping the drill chuck in place, the B-16 Taper fit provides a strong bond and will hold the drill chuck tightly (**Figure 13**).



**Figure 13.** Drill chuck.

4. Refer to **Page 29** for detailed instructions for installing or removing the drill chuck and arbor in the spindle.



# Power Connection

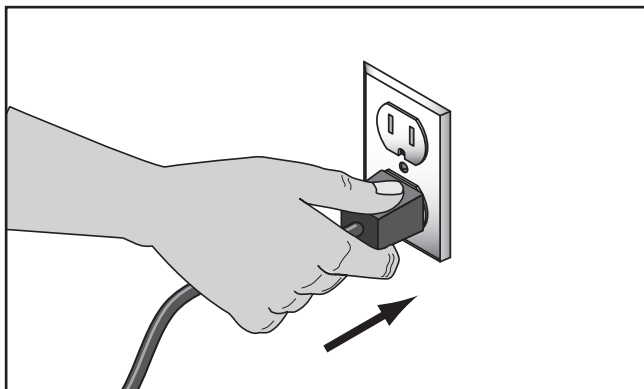
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After you have completed all previous setup instructions and circuit requirements, the machine is ready to be connected to the power supply.

To avoid unexpected startups or property damage, use the following steps whenever connecting or disconnecting the machine.

## Connecting Power

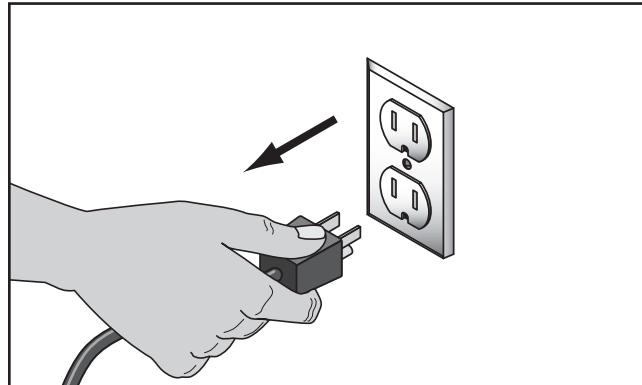
1. Turn the machine power switch **OFF**.
2. Insert the power cord plug into a matching power supply receptacle. The machine is now connected to the power source.



**Figure 14.** Connecting power.

## Disconnecting Power

1. Turn the machine power switch **OFF**.
2. Grasp the molded plug and pull it completely out of the receptacle. Do not pull by the cord as this may damage the wires inside.



**Figure 15.** Disconnecting power.



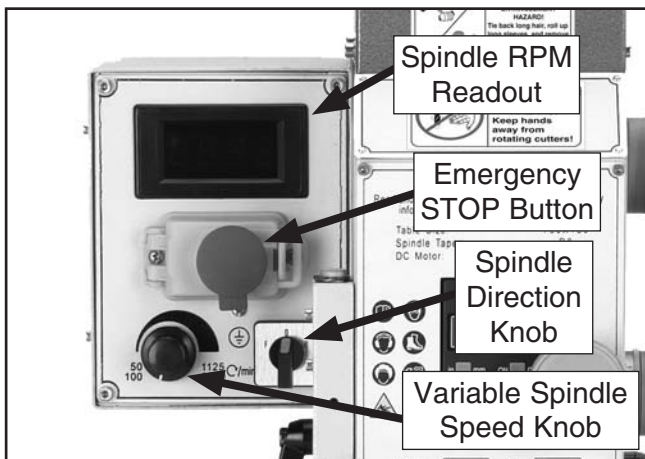


# Test Run & Spindle Break-in

The Model G0704 spindle speed can be set from 50–2250 RPM. You must follow the proper break-in procedures to ensure the spindle bearings break-in and seat before putting any milling load on the machine.

## To test run and break-in the spindle bearings:

1. Do all lubrication procedures highlighted in **Lubrication** in **Section 6: MAINTENANCE** on **Page 36**.
2. Make sure there are no obstructions around or underneath the spindle.
3. Place the spindle direction selection knob in the "0" (OFF) position and press the emergency STOP button (**Figure 16**)



**Figure 16.** Test run controls.

4. Connect the mill/drill to the power source.
5. Turn the speed range selector knob to the "L" (low) position (**Figure 1** on **Page 3**) and rotate the variable spindle speed knob all the way to the left (slowest) position.
6. Place the spindle direction knob in the "F" (Forward) position. Squeeze the tab on the emergency STOP button, pull it open, then press the green button. The spindle will begin to turn at a low RPM.

—When operating correctly, the machine runs smoothly with little or no vibration or rubbing noises.

—Investigate and correct strange or unusual noises or vibrations before operating the machine further. Always disconnect the machine from power when investigating or correcting potential problems.

7. Press the emergency STOP button. The machine should stop.

—If the machine does stop, the emergency STOP button safety feature is working correctly. Continue to **Step 8**.

—If the machine does not stop, the emergency STOP button safety feature is not working correctly. This safety feature must work properly before proceeding with regular operations. Call Tech Support for help.

8. Open the emergency STOP button cover and press the green button to start the spindle.

9. While watching the spindle RPM readout, turn the variable spindle speed knob until the mill/drill reaches approximately 600 RPM, then let it run for a minimum of 10 minutes.

## **NOTICE**

**DO NOT** leave the area while break-in procedure is under way. You must be ready to stop the machine if a problem occurs.

10. Increase the speed to 1000 RPM and let it run for another ten minutes.

11. Increase the speed to 2200 RPM and let it run for another ten minutes.

12. Turn the mill/drill **OFF**.

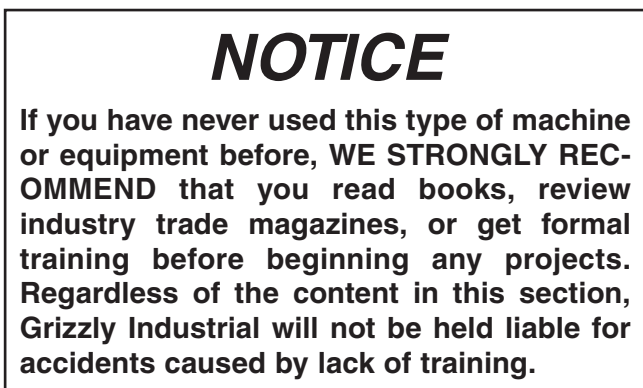
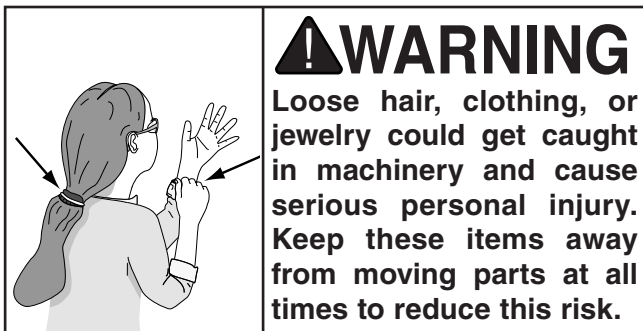
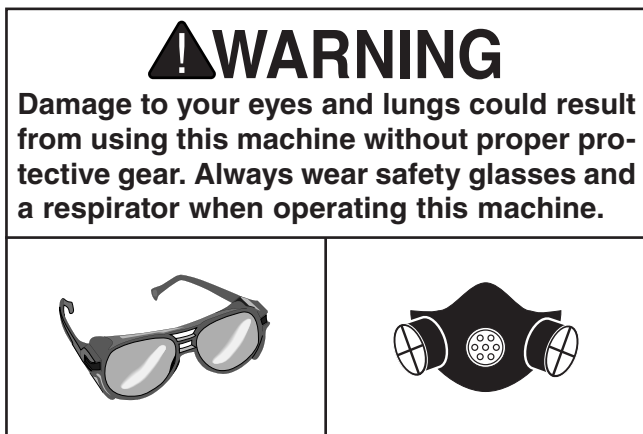
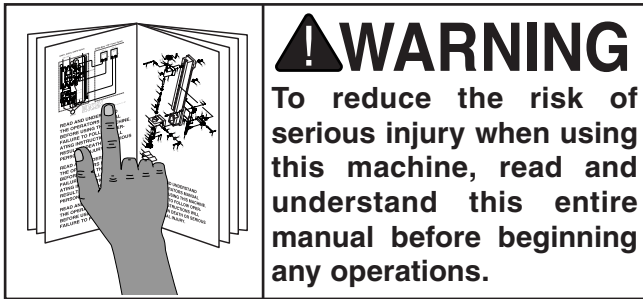
13. Set the spindle to rotate in the opposite direction, then press the green button and let it run at 1000 RPM for another ten minutes.

## **NOTICE**

**Failure to follow start up and spindle break-in procedures will likely cause rapid deterioration of spindle and other related parts.**



# SECTION 4: OPERATIONS



## Basic Controls

Use the descriptions and figures below to become familiar with the basic controls of your machine.

**Vertical Handwheel:** Raises and lowers the headstock (Z-Axis).

**Speed Range Selector Knob:** Selects low range (L) or high range (H) for the spindle speed.

**Vertical Travel Locks:** Lock the position of the headstock to the column.

**Fine Feed Lock Knob:** Engages the fine feed knob for precise control of vertical quill travel.

**Fine Feed Knob:** Provides fine control over vertical quill travel.

**Quill Feed Levers:** Provide coarse control over vertical quill travel.

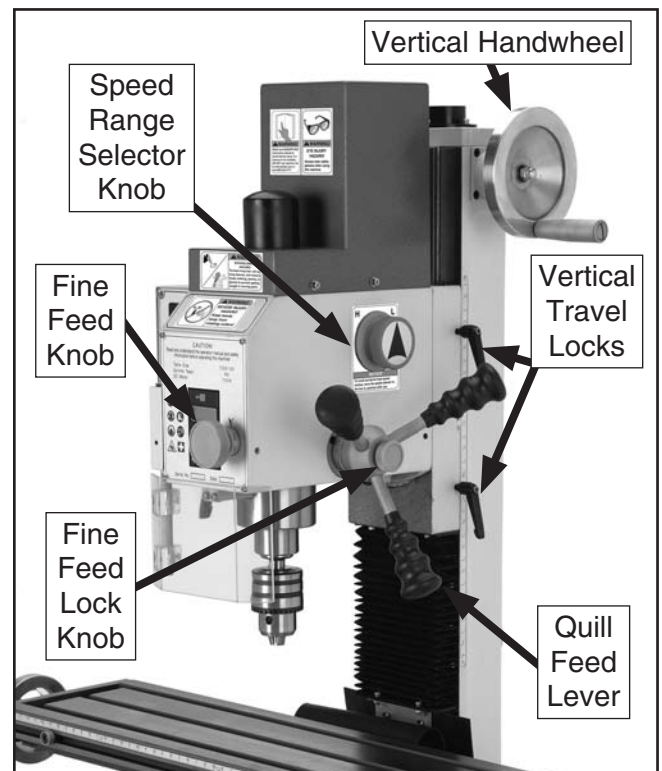


Figure 17. Head controls.





**Drawbar Cap:** Covers the drawbar and upper portion of the spindle.

**Drawbar:** Secures collets and tooling in the spindle taper.

**Spindle and Chuck:** Provide a mounting place for tooling.

**Quill Lock Lever:** Locks the vertical position of the quill when tightened.

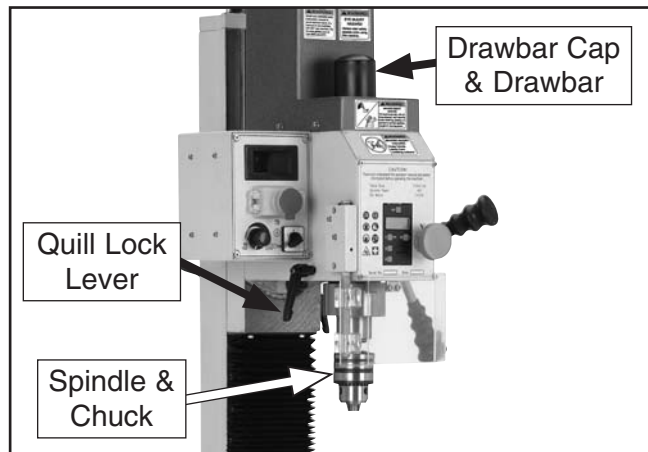


Figure 18. Headstock controls (continued).

**Cross Handwheel:** Moves the table forward and backward (Y-Axis).

**Longitudinal Handwheels:** Move the table from side to side (X-Axis).

**Longitudinal Table Locks:** Lock the longitudinal position of the table when tightened.

**Cross Table Locks:** Lock the cross position of the table when tightened.

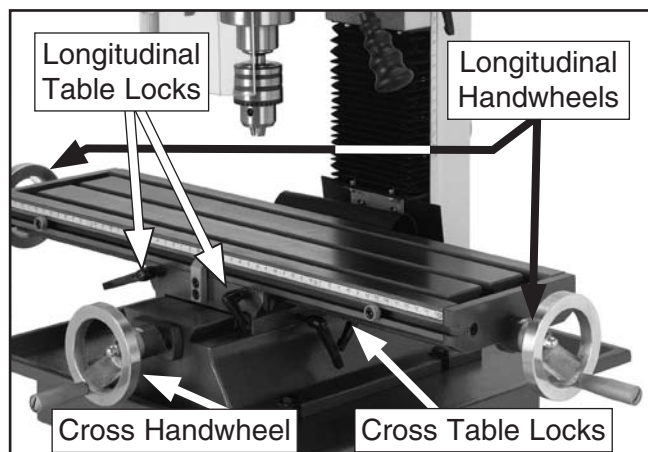


Figure 19. Table controls.

**Spindle RPM Readout:** Displays the speed of the spindle rotation.

**Emergency STOP Button:** Interrupts the flow of power to the machine.

**Variable Spindle Speed Knob:** Changes the speed of the spindle rotation.

**Spindle Direction Selection Knob:** Changes the direction of spindle rotation.

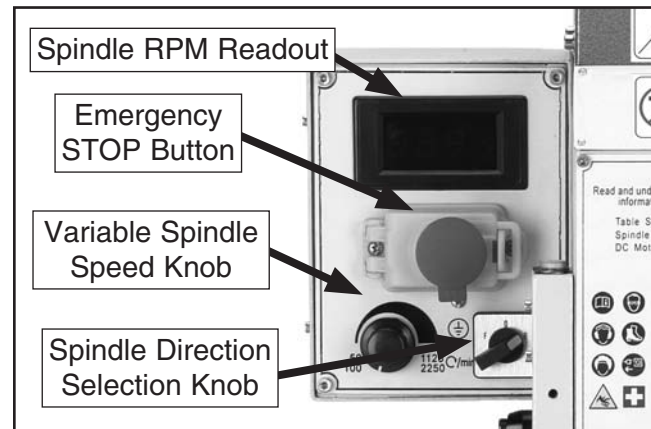


Figure 20. Control panel.

**OFF Button:** Turns **OFF** the display.

**ON/O Button:** Turns **ON** the display with the first press. Pressed again resets the display to 0.000".

**IN/MM Button:** Toggles the units displayed.

**↑ Button:** Increases the current depth reading.

**↓ Button:** Decreases the current depth reading.

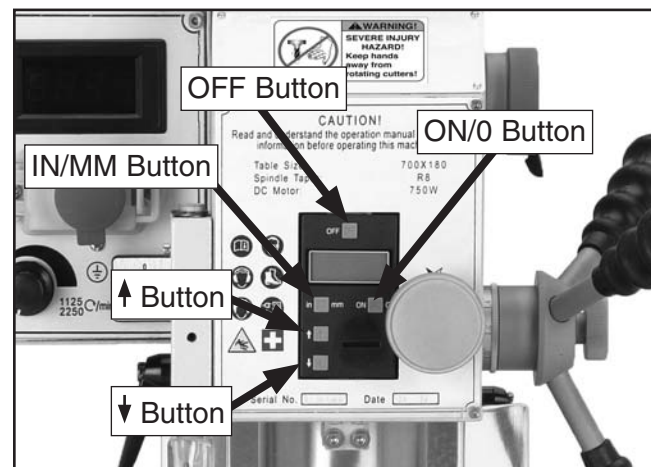


Figure 21. Digital readout unit controls.

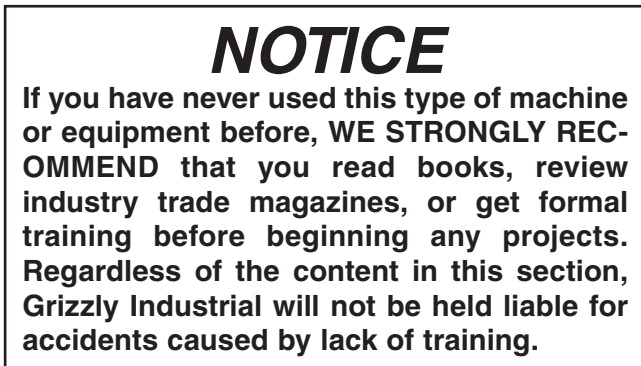
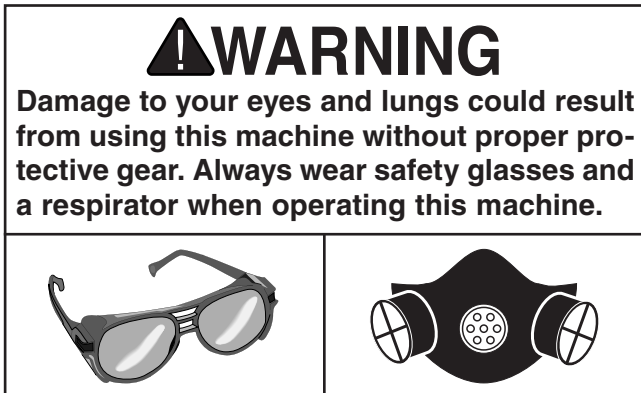


# SECTION 4: OPERATIONS

## Operation Overview

The purpose of this overview is to provide the novice machine operator with a basic understanding of how the machine is used during operation, so the machine controls/components discussed later in this manual are easier to understand.

Due to the generic nature of this overview, it is **not** intended to be an instructional guide. To learn more about specific operations, read this entire manual and seek additional training from experienced machine operators, and do additional research outside of this manual by reading "how-to" books, trade magazines, or websites.



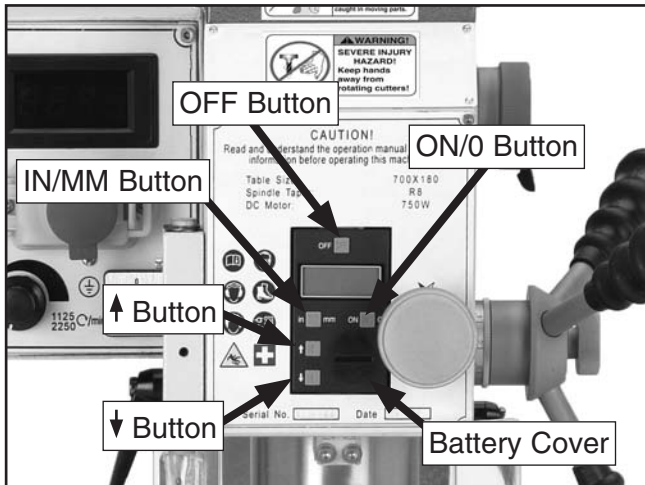
To complete a typical operation, the operator does the following:

1. Loosens the vertical travel locks, then adjusts the headstock height above the table to ensure there is sufficient room to install the tooling in the spindle and the workpiece on the table.
2. Installs the desired tooling for the job.
3. Positions the workpiece as needed for the operation, then clamps the workpiece using applicable clamping devices, or a vise that is already mounted on the table to ensure the workpiece does not move during the milling/drilling operation.
4. Positions the cutter or drill bit near the workpiece, then tightens vertical travel locks.
5. Selects the appropriate spindle speed for the milling or drilling operation using the speed selector knob and variable spindle speed knob.
6. Unlocks the X- and Y-axis table locks.
7. Wears safety glasses or a face shield.
8. Turns the spindle direction selection knob to the desired direction.
9. Loosens the quill lock lever and uses the quill feed lever or the fine feed knob to set the cutting tool height according to the workpiece.
10. For milling operations, uses the table handwheels to move the table so the cutter removes material evenly from the workpiece.  
  
For drilling operations, uses the quill feed lever or fine feed knob to lower the drill bit into the workpiece, then raises the drill bit out of the workpiece using the same controls.
11. Turns the spindle direction knob to the "0" position to stop the spindle.



# Digital Readout Unit

The digital readout unit gives a precise reading of the vertical positioning of the quill. It can be zeroed at any position and manually increased or decreased independent of quill position when the operation requires it (**Figure 22**).



**Figure 22.** Digital readout controls.

## To use the digital readout:

1. Press the ON/O button. A reading should appear on the display.
2. Press the IN/MM button to select whether units will be displayed in inches or millimeters. Each press of the button switches from one unit to the other.
3. If you want to "zero" the readout at any time, press the ON/O button. The current reading will be cleared and the scale will be reset to 0.000.

If you want to increase or decrease the reading at any time, press the appropriate  $\uparrow$  or  $\downarrow$  button. This is useful when calibrating the mill to known dimensions on a workpiece.

4. When the operation is complete, press the OFF button to conserve the battery.

**Note:** *The digital readout unit has an auto-OFF function to save battery life.*



# Calculating Spindle Speed

Closely follow the proper spindle speed and proper feed rate to produce good results, reduce undue strain on all moving parts and increase operator safety.

Prior to milling, determine the spindle speed needed to cut your workpiece, then set the speed on the machine.

## To determine the needed spindle speed:

1. Use the table in **Figure 23** to determine the cutting speed required for the material of your workpiece.
2. Measure the diameter of your cutting tool in inches.
3. Use the following formula to determine the needed spindle RPM for your operation:

$$(\text{Cutting Speed} \times 4) / \text{Tool Diameter} = \text{RPM}$$

Cutting Speeds for High Speed Steel (HSS) Cutting Tools	
Workpiece Material	Cutting Speed (sfm)
Aluminum & Alloys	300
Brass & Bronze	150
Copper	100
Cast Iron, soft	80
Cast Iron, hard	50
Mild Steel	90
Cast Steel	80
Alloy Steel, hard	40
Tool Steel	50
Stainless Steel	60
Titanium	50
Plastics	300-800
Wood	300-500

**Note:** For carbide cutting tools, double the cutting speed. These values are a guideline only. Refer to the *MACHINERY'S HANDBOOK* for more detailed information.

**Figure 23.** Cutting speed table for HSS cutting tools.



# Spindle Speed and Direction

Setting the speed on the Model G0704 is a two part process. The gearbox in the headstock has two gear ranges and the motor is a variable speed unit. Together, these two systems provide an overall speed range of 50–2250 RPM.

## To set the spindle speed:

1. Determine the appropriate spindle speed for your operation. See **Calculating Spindle Speed** on **Page 26**.
2. Select the appropriate speed range using the speed range selector knob (**Figure 24**). "H" represents the high speed range, which is capable of spindle speeds from 100–2250 RPM. "L" represents the low range, which is capable of spindle speeds from 50–1125 RPM.

**Note:** To maximize spindle torque, use the low range except when the required spindle RPM is over the low range maximum of 1125 RPM.

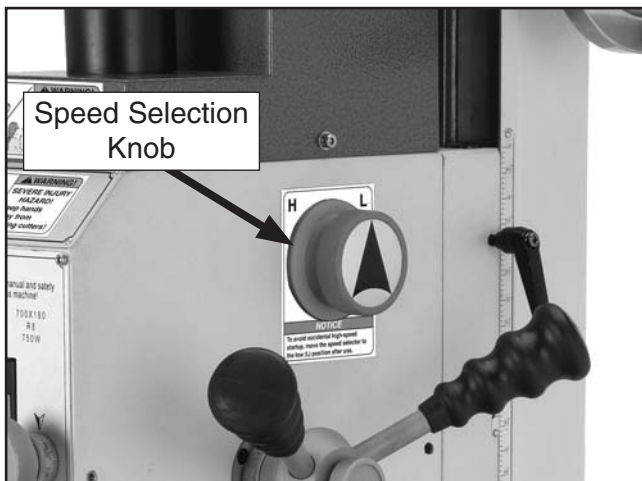


Figure 24. Speed selector knob.

**Note:** It may be necessary to rotate the spindle by hand to get the gears to mesh properly.

3. Make sure the work area is clear and that all safety precautions are taken.
4. Turn the variable spindle speed knob to the far left (slowest) position, then press the green start button and use the spindle direction selection knob to choose the direction of spindle travel and start spindle rotation (**Figure 25**).

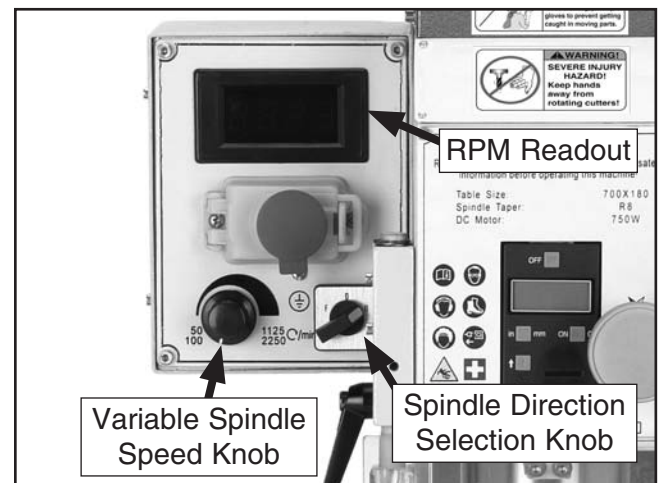


Figure 25. Spindle direction selection knob.

5. Watch the RPM readout and adjust the variable spindle speed knob as needed until the desired RPM is reached.

## NOTICE

### AVOID OVERHEATING MOTOR!

**DO NOT** operate with variable speed dial at full RPM for than a couple minutes or motor overheating may occur. Instead, achieve the same spindle speed by using the high "H" speed range and reducing the motor RPM by turning the variable speed dial down.





# Spindle Height Controls

The spindle height is controlled by the quill feed lever and the fine feed knob.

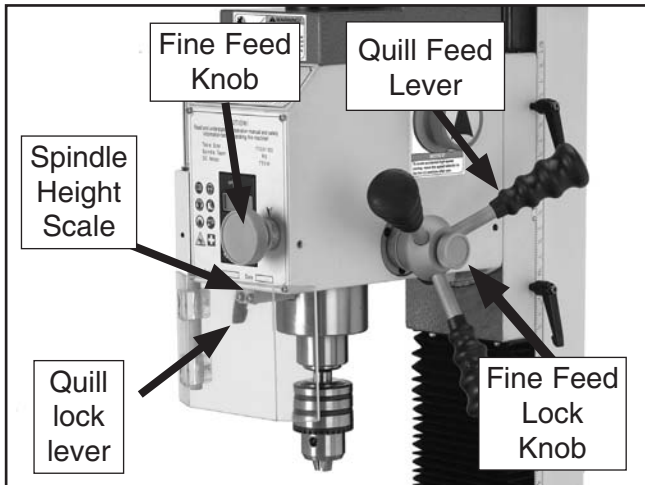


Figure 26. Spindle controls.

## Changing Spindle Position Using Quill Feed Levers

1. Unlock the quill lock lever and loosen the fine feed lock knob.
2. Pull down on any of the coarse downfeed levers to adjust the vertical position of the spindle. Observe the spindle height scale or digital readout to monitor movement in inches or millimeters.

**Tip:** Milling with the spindle fully extended can cause tool chatter. For maximum spindle rigidity when milling, it is better to keep the spindle retracted into the headstock as far as possible with the spindle lock and the downfeed selector knob tightened.

## Changing Spindle Position Using Fine Feed Knob

1. Unlock the quill lock lever and tighten the fine feed lock knob.
2. Rotate the fine feed knob to lower or raise the spindle in small increments. Observe the scale on the knob or the digital readout to monitor movement in thousandths of an inch (Figure 27).

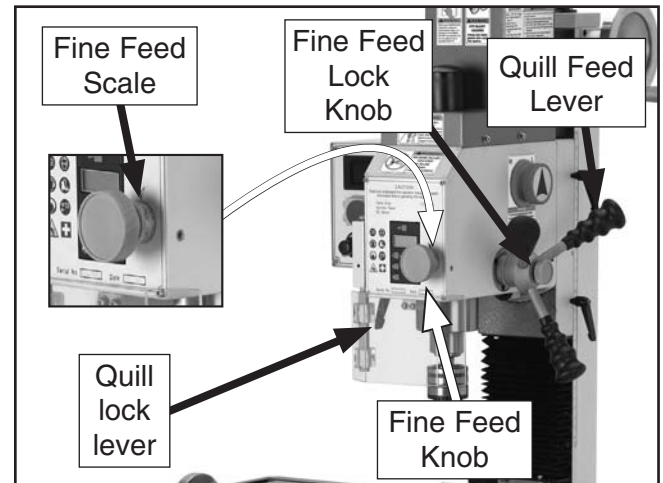


Figure 27. Fine spindle feed controls.

3. Tighten the quill lock lever to hold the spindle in a particular position if you choose.

**Tip:** Milling with the spindle fully extended can cause tool chatter. For maximum spindle rigidity when milling, it is better to keep the spindle retracted into the headstock as far as possible with the quill lock lever tightened, and the fine feed knob tightened.



# Drill Chuck

## To install the drill chuck and arbor:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the drawbar cap.
3. Insert the chuck arbor into the spindle, making sure to line up the slot in the arbor with the pin in the spindle.
4. Thread the drawbar into the arbor until the arbor is seated up into the spindle taper.
5. Use a 17mm wrench to prevent the spindle from turning while you use an 8mm wrench to snug the drawbar, as shown in **Figure 28**.



**Figure 28.** Snugging the drawbar.

**Note:** Do not overtighten the drawbar. Overtightening makes arbor removal difficult and will damage the arbor and threads.

6. Re-install the drawbar cap.

## **NOTICE**

The Model G0704 drawbar will extract the arbor from the spindle. Once the arbor or collet has broken free from the spindle taper, be sure to properly support it while continuing to loosen the drawbar. Failure to properly support the arbor or collet while loosening the drawbar will result in the arbor or collet falling out of the spindle, causing damage to machine components.

## To remove the chuck and arbor from the spindle:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the drawbar cap.
3. Lock the quill in place with the quill lock lever.
4. Use a 17mm wrench to prevent the spindle from turning while you use an 8mm wrench to loosen the drawbar 2–3 turns. DO NOT continue loosening the drawbar without supporting the drill chuck or it will fall from the spindle.
5. Hold the chuck with one hand and finish loosening the drawbar until the chuck falls out of the spindle.

**Note:** The chuck is attached to the arbor using a B-16 taper. This attachment is considered to be semi-permanent. There should be no need to remove the chuck from the arbor.



# Loading Tooling

Your Model G0704 features an R-8 spindle taper, which gives the freedom to use standard R-8 cutting tools and collets. These optional collets come in many sizes, typically ranging from 1/16" to 7/8" and 3mm to 20mm, and should be matched to your cutting tool shank size.

## To install the tooling:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the drawbar cap.
3. Carefully clean the surface of the tooling and spindle taper. Ensure that it is free of debris and is lightly oiled.
4. If you are using a cutting tool and collet, insert the cutting tool into the collet, then insert the collet up into the spindle taper, making sure the slot in the collet lines up with the pin in the spindle.

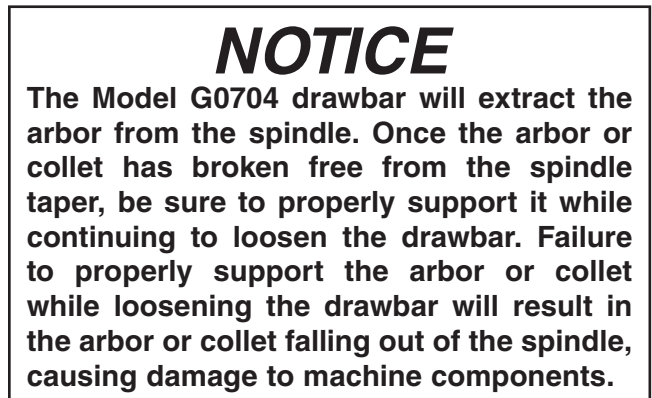
If you are using a cutting tool that installs directly into the spindle, insert the tool into the spindle taper, making sure the slot in the tool lines up with the pin in the spindle.

5. Slide the tooling upward until it makes contact with the drawbar threads.
6. Hand thread the drawbar into the tooling until the tooling draws up into the spindle taper.
7. Use a 17mm wrench to prevent the spindle from turning while you use an 8mm wrench to snug the drawbar.

**Note:** *Do not overtighten the drawbar. Overtightening makes collet removal difficult and will damage the drawbar threads, collet, and the spindle taper. Keep in mind that the taper keeps the collet and tool in place. The drawbar simply aids in seating the taper.*

## To remove the collet:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the drawbar cap.
3. Lock the quill in place with the quill lock lever.
4. Use a 17mm wrench to prevent the spindle from turning while you use an 8mm wrench to loosen the drawbar 2–3 turns. DO NOT continue loosening the drawbar without supporting the collet or it will fall from the spindle.



5. Protect the table surface with a piece of cardboard and hold the cutter/tool with a shop towel to prevent it from falling out of the collet. Continue loosening the drawbar until the collet is freed from the spindle.



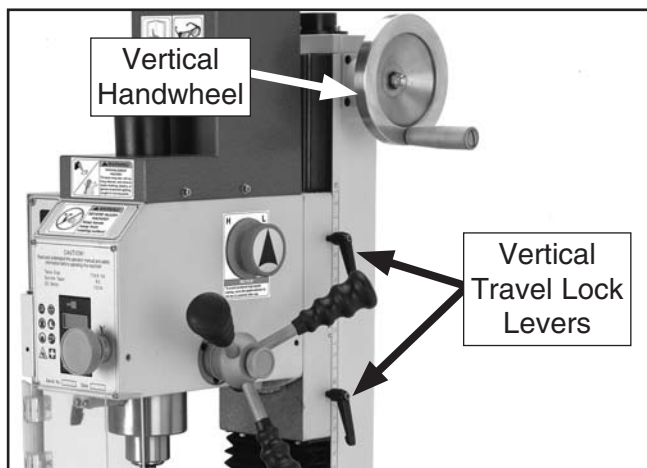


# Headstock Travel (Z-Axis and Rotation)

Headstock height is adjustable in the vertical Z-axis to accept large workpieces. For unique milling operations, the headstock can be tilted right or left between 0° and 90°.

**To raise or lower the headstock:**

1. Unlock the vertical travel lock levers shown in **Figure 29**.



**Figure 29.** Headstock slide controls.

2. Turn the vertical handwheel shown in **Figure 29** to raise or lower the headstock, then lock the vertical travel lock levers.

**Note:** For maximum spindle rigidity when milling, keep the spindle retracted into the headstock as far as possible with the quill lock lever locked and with the fine feed lock knob tightened.

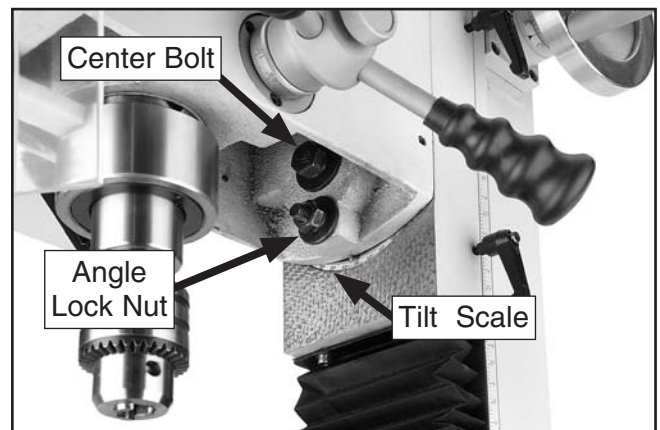
**To tilt the headstock to the left or right:**

1. DISCONNECT MILL/DRILL FROM POWER.

## **CAUTION**

During the following steps, be aware that the headstock is top-heavy and will swing if it is not well supported once the center bolt and lock nut are loosened. Always support the headstock with one hand when loosening these fasteners. Failure to do so may result in unexpected movement of the headstock, causing damage to the machine and personal injury.

2. Support the headstock with one hand, then using the included 17/19mm combo wrench, loosen the headstock center bolt and angle lock nut (**Figure 30**).



**Figure 30.** Headstock tilt controls.

3. While watching the tilt scale, rotate the headstock to the required angle, then retighten the center bolt and angle lock nut to hold the headstock in place.



# Table Travel

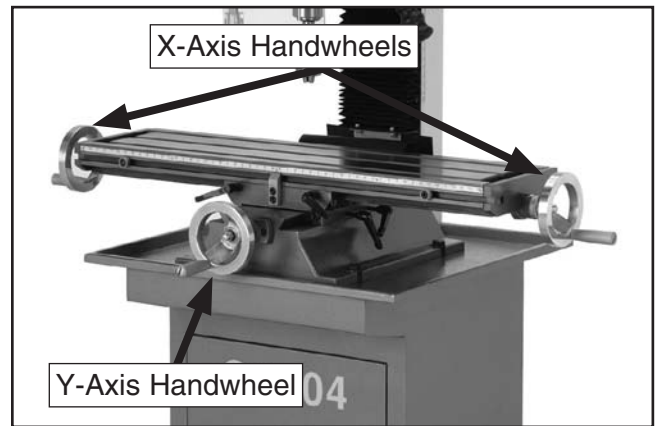
The mill/drill table can be moved in the longitudinal (X-axis) and cross (Y-axis) directions.

## Longitudinal Feed

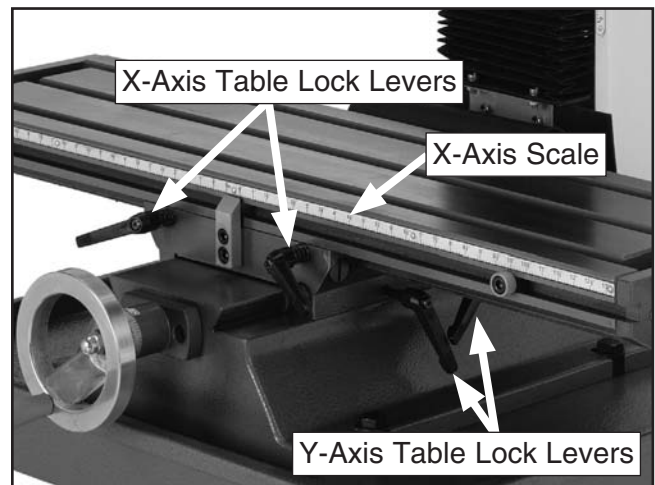
The X-axis is moved by the handwheels shown in **Figure 31** at the end of the table. These handwheels will move the table in both directions side-to-side. One complete revolution of either handwheel moves the longitudinal feed 0.100". There is also a scale on the front of the table for use when a tight tolerance is not required. The longitudinal feed can be locked in position by table locks located on the front of the table (see **Figure 32**).

## Cross Feed

The Y-axis shown in **Figure 31**, is moved with the handwheel on the front of the table base. One complete revolution of the handwheel moves the cross slide 0.100". The cross feed can be locked into position by a table lock lever located on the right side of the cross slide underneath the table (see **Figure 32**).



**Figure 31.** Table X- and Y-axis controls.



**Figure 32.** Table locks and scales.



# SECTION 5: ACCESSORIES

## **⚠️ WARNING**

Some aftermarket accessories can be installed on this machine that could cause it to function improperly, increasing the risk of serious personal injury. To minimize this risk, only install accessories recommended for this machine by Grizzly.

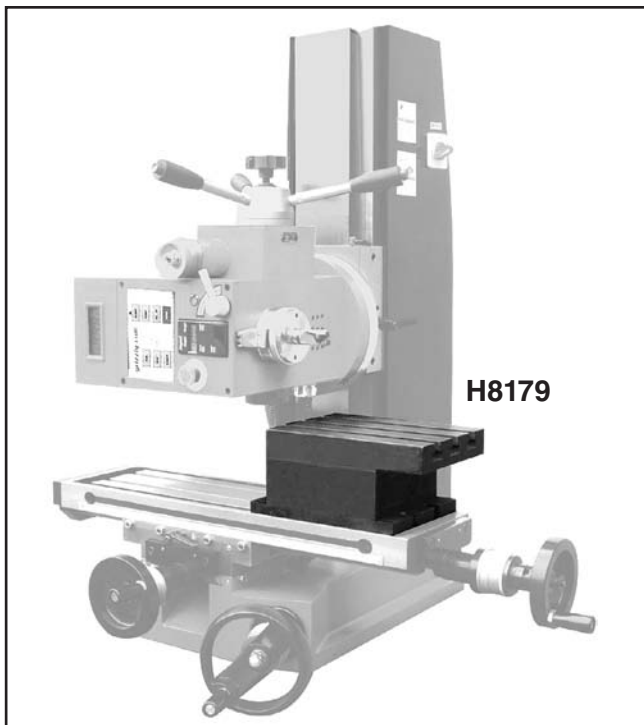
## **NOTICE**

Refer to [www.grizzly.com](http://www.grizzly.com) or the newest copy of the Grizzly Catalog for other accessories available for this machine.

**Call 1-800-523-4777 To Order**

### **H8179—Horizontal Milling Table**

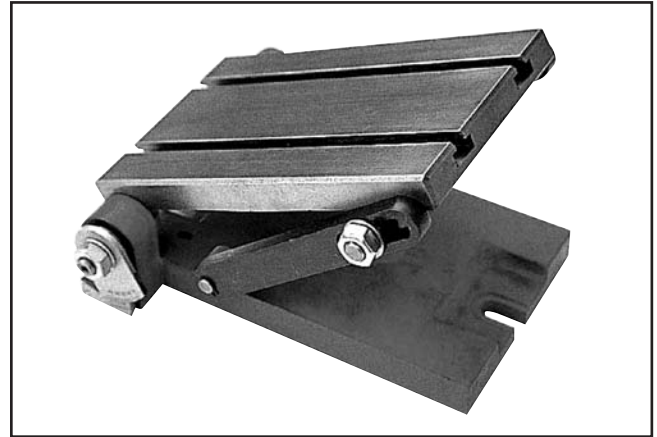
Take advantage of the G0704 mill/drill 90° tilting headstock feature. Install this lifted cast-iron horizontal milling table for the correct clearance when making those side-milling operations.



**Figure 33.** Horizontal milling worktable.

### **H8177—Worktable with Angle**

Enjoy having an economical way to support your workpiece at an array of angles. This high-quality tilting worktable is quick and easy to setup and use.



**Figure 34.** Worktable with angle.

### **T10063—Milling Vise 12<sup>5</sup>/<sub>16</sub>" x 6<sup>9</sup>/<sub>16</sub>"**

### **T10064—Milling Vise 17<sup>1</sup>/<sub>8</sub>" x 8<sup>3</sup>/<sub>4</sub>"**

- Ultra precise in flatness, parallelism and verticality.
- Anti-lift mechanism ensures the workpiece does not lift when jaws are tightened.
- Ductile iron body.
- Flame hardened vise bed and jaws.
- Sealed bearing system.
- 8200 lbs. of clamping pressure.



**Figure ??.** T10064 Milling vise (handle included, but not shown).



### G9322—Boring Head Combo Set

Hardened and ground adjusting screws along with a wide base design guarantee a long life and trouble-free use. Includes a 2" boring head, R-8 arbor with  $\frac{7}{16}$ "-20 TPI, and a 12 piece  $\frac{3}{4}$ " boring bar set.



Figure 35. G9324 Boring Head Combo Set.

### G9760—20-PC. 2 & 4 Flute TiN End Mill Set.

Includes these sizes and styles in two and four flute styles:  $\frac{3}{16}$ ",  $\frac{1}{4}$ ",  $\frac{5}{16}$ ",  $\frac{3}{8}$ ",  $\frac{7}{16}$ ",  $\frac{1}{2}$ ",  $\frac{9}{16}$ ",  $\frac{5}{8}$ ",  $\frac{3}{8}$ ",  $\frac{11}{16}$ ", and  $\frac{3}{4}$ ".



Figure 36. G9760 20-PC End Mill Set.

### G8683Z—Mini Shop Fox® Mobile Base

Don't let the little size of this one fool you. It shares the same design concepts as its two bigger brothers, giving you an amazing 600 lb. load capacity in one small package!

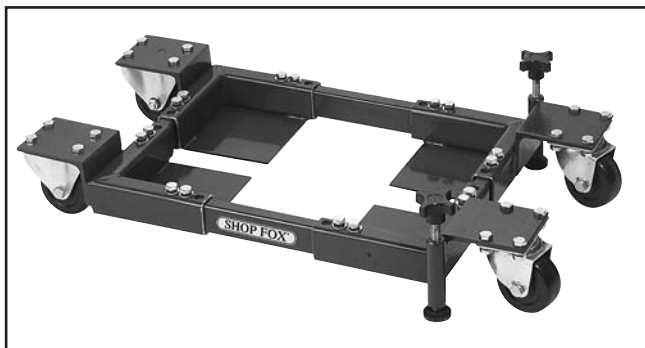


Figure 37. Model G8683 Mini Shop Fox® Mobile Base.

### T10067—8 Pc. R-8 Quick Change Collet Set

### T10068—16 Pc. R-8 Quick Change Collet Set

These are the best collet sets we've ever carried. They can be used in production shops and for high precision work. Includes R-8 quick change collet chuck,  $\frac{1}{4}$ ",  $\frac{5}{16}$ ",  $\frac{3}{8}$ ",  $\frac{1}{2}$ ",  $\frac{5}{8}$ ",  $\frac{3}{4}$ " and 1" collets, spanner wrench and moulded plastic case. The 16 pc. set includes everything in the 8 pc. set plus  $\frac{1}{8}$ ",  $\frac{3}{16}$ ",  $\frac{7}{16}$ ",  $\frac{9}{16}$ ",  $\frac{11}{16}$ ",  $\frac{13}{16}$ ",  $\frac{7}{8}$ ", and  $\frac{15}{16}$ " collets. Made in Taiwan!



Figure 38. T10067 & T10068 Collet Sets.

### H5685—4" Rotary Table

The perfect rotary table for all you model makers and those doing smaller precision work. Comes with clamping kit.

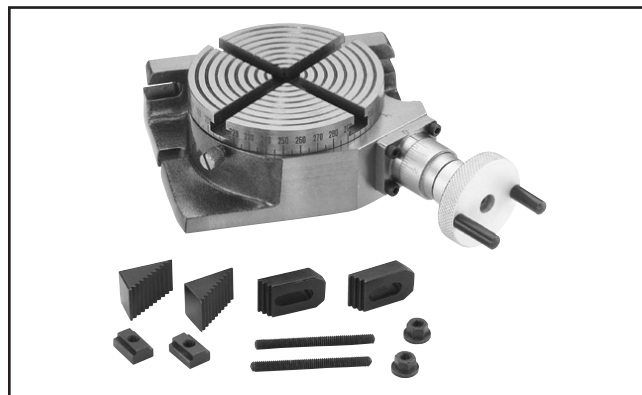


Figure 39. H5685 4" Rotary Table.

### H8257—Primrose Armor Plate with Moly-D Machine and Way Oil 1 Quart

This superior machine and way lubricant prevents stick slip and chatter due to anti-friction capabilities resulting in greater precision machining capabilities. Provides the thinnest oil film possible while effectively providing needed lubrication and rust/corrosion protection. Adhesive/cohesive components are added for vertical surfaces. Resists squeeze out, running, dripping and non-gumming.

Call 1-800-523-4777 To Order





**G9511—T-Slot Nuts, 4 PK, 7/16" Slot, 3/8"-16**

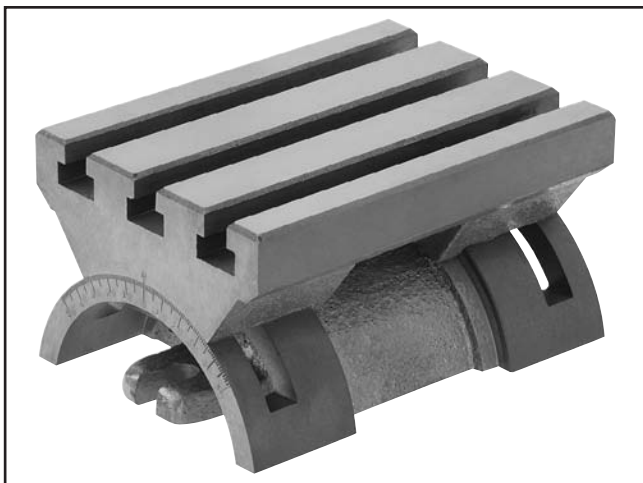
Heat treated steel T-Slot Nuts with black oxide finish feature an imperfect thread in the base of the T-nut to eliminate any danger of screwing the clamping stud through and damaging the table slot.



**Figure 40.** Model G9511 T-Slot Nuts.

**G5758—Tilt Table 5" x 7"**

Set your work at any angle with these sturdy tilt tables. Heavy-duty construction includes T-slots, two locking screws and precision base that allows the table to tilt from -45 Degrees to +45 Degrees. Table size: 5" x 7".



**Figure 41.** Model G5758 Tilt Table.

**Call 1-800-523-4777 To Order**

**G9849—Magnetic Base/Dial Indicator Combo**

Precision measurements and setups have never been so easy. Magnetic base engages with just the turn of a switch and allows pinpoint adjustment. The dial indicator features 0-1" travel and has a resolution of 0.001". This fine set includes a molded case for protection and convenience.



**Figure 42.** Model G9849 Indicator/Base Combo

**G5684—R-8 Vertical Collet Rack**

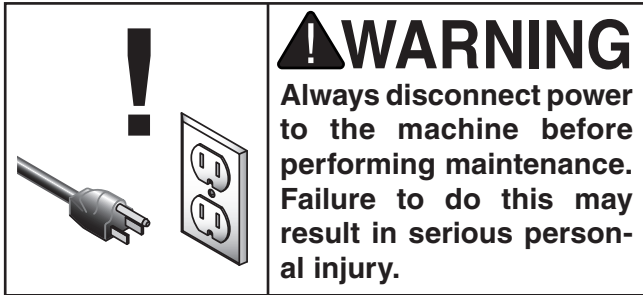
No more loose R-8 collets laying around in your tool box. Organize with this handy collet rack and you won't be looking at each one for the correct size. Set on your bench or mount to a wall. Holds 48 collets.



**Figure 43.** Model G5684 Tilt Table.



# SECTION 6: MAINTENANCE



## Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

### Daily Check:

- Make sure mill/drill is disconnected from power when not in use.
- Check for loose mounting bolts.
- Make sure mill/drill is clean and lubricated.
- Check for worn or damaged wires.
- Check for any other unsafe condition.

### Monthly Check:

- Check that gibs are adjusted properly.

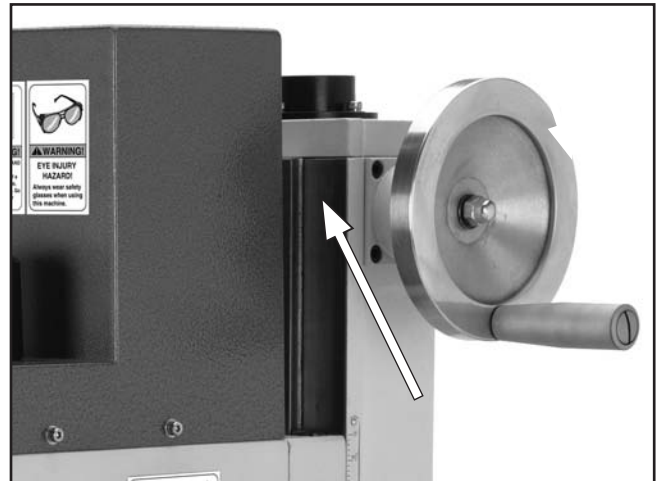
### Biannual Check:

- Lubricate headstock lead screw and gears.

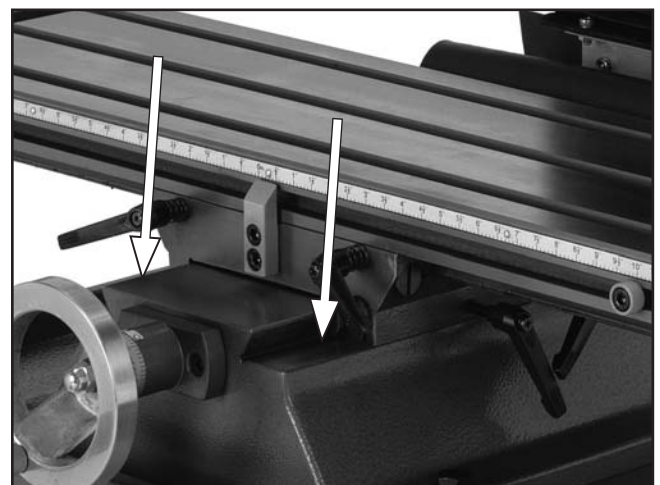
## Lubrication

Regular lubrication will ensure your mill/drill performs at its highest potential. Regularly wipe all sliding surfaces with Primrose® Way Oil (**Page 34**) or a light machine oil, then move the components back and forth several times to ensure smooth movements (**Figures 44–46**). Every six months, or more often with heavy use, clean and lubricate the leadscrews and vertical handwheel ring & pinion gears, as outlined on **Page 38**.

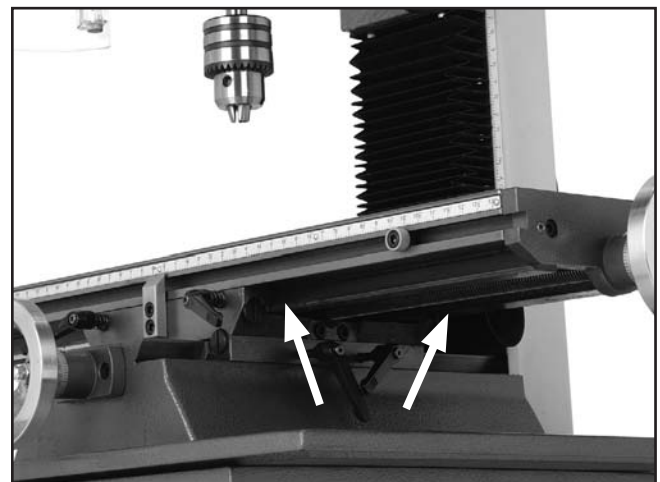
Protect other unpainted cast iron surfaces with regular applications of products like G96® Gun Treatment, SLIPIT®, or Boeshield® T-9.



**Figure 44.** Vertical way lube location (both sides).



**Figure 45.** Cross way lube locations.



**Figure 46.** Longitudinal way lube locations.

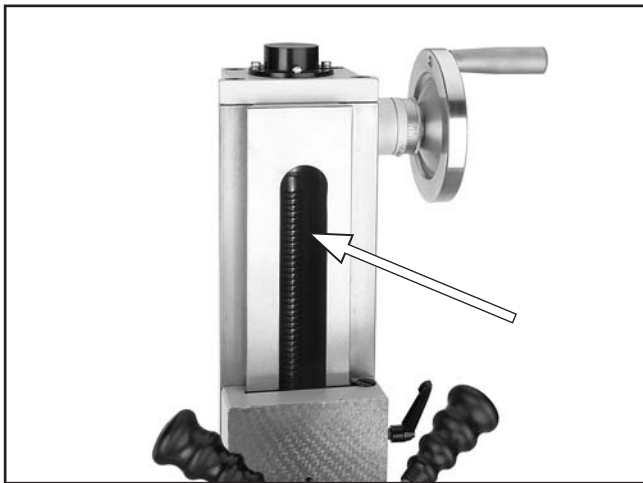


Every six months, or more frequently under heavy use, we recommend that you clean and lubricate the leadscrews and vertical handwheel gears with a light machine oil and multi-purpose grease.

<b>Tools Needed:</b>	<b>Qty</b>
Hex Wrench 3, 4mm.....	1
Multi-Purpose Lithium Grease.....	1
Paint Brush for Grease Application .....	1
Oil Bottle of 10-30w Synthetic Oil .....	1
Stiff-Bristled Nylon Brush for Cleaning.....	1
Mineral Spirits.....	As needed for cleaning
Shop Rags.....	As needed for cleaning

**To lubricate the leadscrews:**

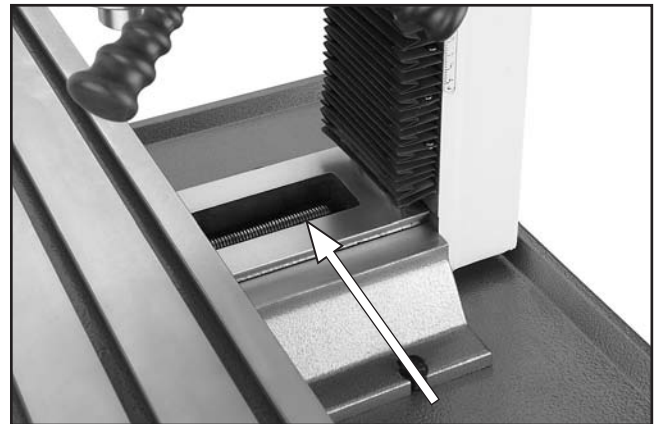
1. DISCONNECT MILL/DRILL FROM POWER!
2. Lower the headstock as far as you can without the spindle contacting the table surface.
3. Use mineral spirits and a brush to clean as much of the existing grease and debris as possible off of the vertical leadscrew shown in **Figure 47**. Allow leadscrew to dry.



**Figure 47.** Vertical leadscrew location.

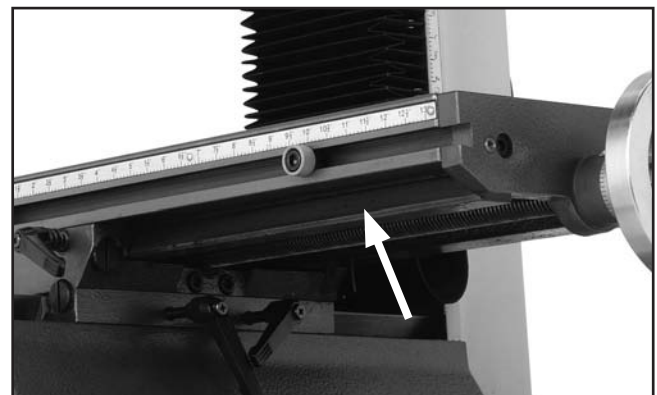
4. Apply light machine oil to the exposed leadscrew threads, then move the headstock through its full range of motion several times to disperse the oil along the full length of the leadscrew.
5. Using the cross handwheel, move the table as far forward as possible.

6. Lift or remove the rubber way cover, then use mineral spirits and a brush to clean as much of the existing grease and debris as possible off of the cross travel leadscrew shown in **Figure 48**. Allow leadscrew to dry.



**Figure 48.** Cross travel leadscrew location.

7. Apply light machine oil to the exposed leadscrew threads, then move the table through its full range of cross motion several times to disperse the oil along the full length of the leadscrew.
8. Using the longitudinal handwheel, move the table as far to one side as possible.
9. From beneath the table, use mineral spirits and a brush to clean as much of the existing grease and debris as possible off of the longitudinal travel leadscrew shown in **Figure 49**. Allow the leadscrew to dry.



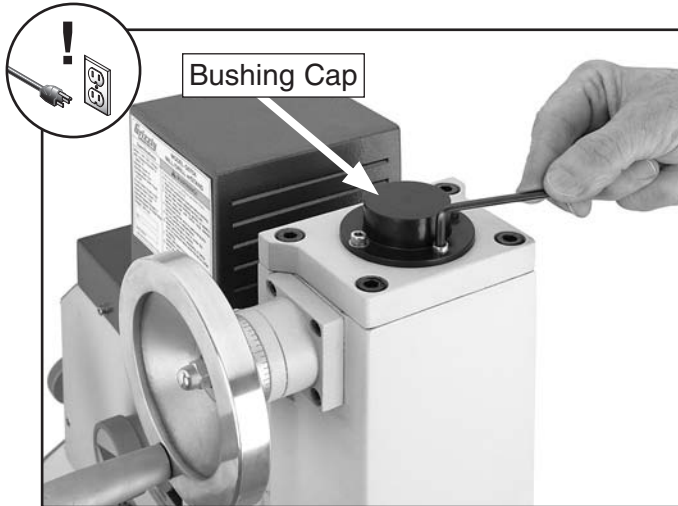
**Figure 49.** Longitudinal leadscrew location.

10. Apply light machine oil to the exposed leadscrew threads, then move the table through its full range of longitudinal motion several times to disperse the oil along the full length of the leadscrew.



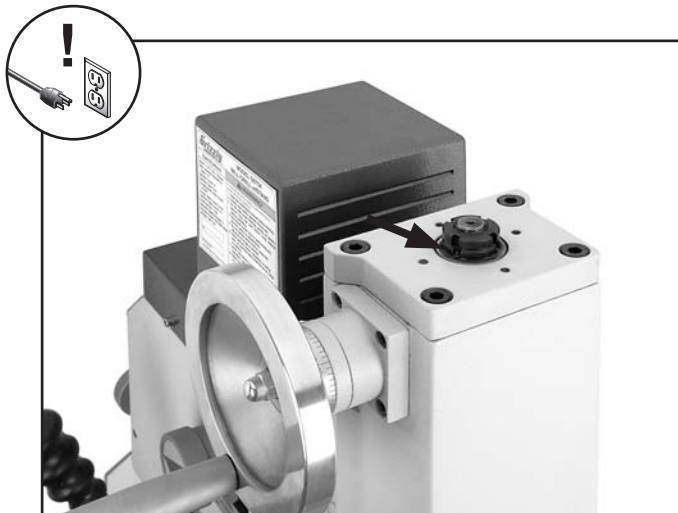
**To lubricate the vertical leadscrew bushing and ring & pinion gears:**

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the bushing cap by unthreading the four cap screws that secure it (**Figure 50**).



**Figure 50.** Bushing cap removal.

3. Apply several drops of light machine oil to the bushing edge, then rotate the vertical handwheel to disperse the oil (**Figure 51**).



**Figure 51.** Bushing oil location.

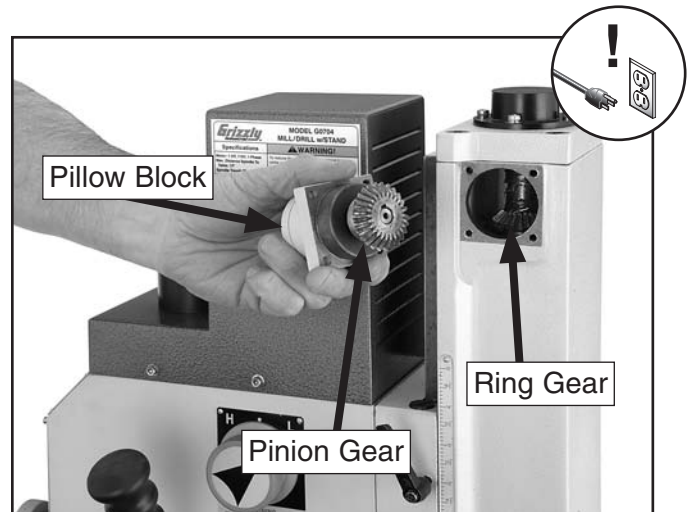
4. Replace the bushing cap.

5. Remove the acorn nut and flat washer that secure the vertical handwheel, then remove the handwheel (**Figure 52**).



**Figure 52.** Handwheel removal.

6. Remove the four cap screws that secure the handwheel shaft pillow block, then carefully remove the assembly (**Figure 53**).



**Figure 53.** Handwheel gears.

7. Use mineral spirits and a brush and rag to clean as much of the existing grease and debris as possible off of the ring and pinion gears. Allow the parts to dry.
8. Apply a liberal coat of multi-purpose grease to the pinion gear.
9. Re-assemble the machine by reversing the steps above.



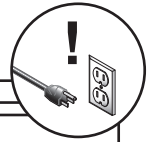


# SECTION 7: SERVICE

Review the troubleshooting and procedures in this section if a problem develops with your machine. If you need replacement parts or additional help with a procedure, call our Technical Support at (570) 546-9663.

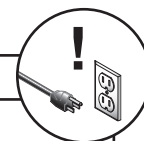
**Note:** Please gather the serial number and manufacture date of your machine before calling.

## Troubleshooting



Symptom	Possible Cause	Possible Solution
Machine does not start.	<ol style="list-style-type: none"> <li>1. Circuit breaker on machine tripped.</li> <li>2. Plug at fault or wired incorrectly.</li> <li>3. Motor wired incorrectly.</li> <li>4. Wall fuse/circuit breaker is blown/tripped.</li> <li>5. Wiring is open/has high resistance.</li> <li>6. Machine power switch is at fault.</li> <li>7. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Press reset button on motor junction box; reduce load on motor to prevent overheating.</li> <li>2. Ensure plug is not damaged and is wired correctly.</li> <li>3. Ensure motor wiring is correct.</li> <li>4. Ensure circuit size is correct and a short does not exist. Reset breaker or replace fuse.</li> <li>5. Check for broken wires or disconnected/corroded connections; repair/replace as necessary.</li> <li>6. Ensure switch is wired correctly; replace if at fault.</li> <li>7. Test/repair/replace.</li> </ol>
Machine stalls or is overloaded.	<ol style="list-style-type: none"> <li>1. Feed rate/cutting speed too fast.</li> <li>2. Wrong cutter type.</li> <li>3. Machine is undersized for the task or tooling is incorrect for the task.</li> <li>4. Motor connection is wired incorrectly.</li> <li>5. Motor bearings are at fault.</li> <li>6. Motor has overheated.</li> <li>7. Motor is at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease feed rate/cutting speed.</li> <li>2. Use the correct cutter for the task.</li> <li>3. Use smaller or sharper tooling; reduce feed rate or spindle speed; use cutting fluid if possible.</li> <li>4. Wire motor correctly for the intended voltage.</li> <li>5. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> <li>6. Clean off motor, let cool, and reduce workload.</li> <li>7. Test/repair/replace motor.</li> </ol>
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> <li>1. Motor or machine component is loose.</li> <li>2. Excessive depth of cut.</li> <li>3. Cutter/tooling is loose.</li> <li>4. Cutter is dull or at fault.</li> <li>5. Bit is chattering.</li> <li>6. Machine is incorrectly mounted or sits unevenly.</li> <li>7. Motor bearings are at fault.</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect/replace stripped or damaged bolts/nuts, and re-tighten with thread locking fluid.</li> <li>2. Decrease depth of cut.</li> <li>3. Make sure tooling is properly secured.</li> <li>4. Replace/resharpen cutter.</li> <li>5. Replace/sharpen bit; index bit to workpiece; use appropriate feed rate and cutting RPM.</li> <li>6. Tighten/replace mounting bolts in bench; relocate/shim machine.</li> <li>7. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement.</li> </ol>





Symptom	Possible Cause	Possible Solution
Tool slips in collet.	<ol style="list-style-type: none"> <li>1. Collet is not fully drawn up into spindle taper.</li> <li>2. Wrong size collet.</li> <li>3. Debris on collet or in spindle taper.</li> <li>4. Taking too big of a cut.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten drawbar.</li> <li>2. Measure tool shank diameter and match with appropriate diameter collet.</li> <li>3. Clean collet and spindle taper.</li> <li>4. Lessen depth of cut and allow chips to clear.</li> </ol>
Breaking tools or cutters.	<ol style="list-style-type: none"> <li>1. Spindle speed too slow/feed rate is too fast.</li> <li>2. Cutting tool getting too hot.</li> <li>3. Taking too big of a cut.</li> <li>4. Spindle extended too far down.</li> </ol>	<ol style="list-style-type: none"> <li>1. Set spindle speed correctly (<b>Page 27</b>) or use a slower feed rate.</li> <li>2. Use coolant fluid or oil for appropriate application. (Follow cutting fluid manufacturer's recommendation for proper use and safety.)</li> <li>3. Decrease depth of cut.</li> <li>4. Fully retract spindle and lower headstock. This increases rigidity.</li> </ol>
Workpiece vibrates or chatters during operation.	<ol style="list-style-type: none"> <li>1. Table locks not tight.</li> <li>2. Quill lock lever not tight.</li> <li>3. Workpiece not securely clamped to table or into mill vice.</li> <li>4. Spindle speed is too slow /feed rate is too fast.</li> <li>5. Spindle extended too far down.</li> </ol>	<ol style="list-style-type: none"> <li>1. Tighten down table locks (<b>Page 32</b>).</li> <li>2. Tighten quill lock lever.</li> <li>3. Check that clamping is tight and sufficient for the job. Make sure mill vice is tight to the table.</li> <li>4. Set spindle speed correctly (<b>Page 27</b>) or use a slower feed rate.</li> <li>5. Fully retract spindle and lower headstock. This increases rigidity.</li> </ol>
Table is hard to move.	<ol style="list-style-type: none"> <li>1. Table locks are tightened down.</li> <li>2. Chips have loaded up on ways.</li> <li>3. Ways are dry and need lubrication.</li> <li>4. Table limit stops are interfering.</li> <li>5. Gibs are too tight.</li> </ol>	<ol style="list-style-type: none"> <li>1. Make sure table locks are fully released.</li> <li>2. Frequently clean away chips that load up during milling operations.</li> <li>3. Lubricate ways and handles (<b>Page 36</b>).</li> <li>4. Check to make sure that all table limit stops are not in the way.</li> <li>5. Adjust gibs (see <b>Page 41</b>).</li> </ol>
Bad surface finish.	<ol style="list-style-type: none"> <li>1. Spindle speed is too slow/feed rate is too fast.</li> <li>2. Using a dull or incorrect cutting tool.</li> <li>3. Wrong rotation of cutting tool.</li> <li>4. Workpiece not securely clamped.</li> <li>5. Spindle extended too far down.</li> </ol>	<ol style="list-style-type: none"> <li>1. Set spindle speed correctly (<b>Page 27</b>) or use a slower feed rate.</li> <li>2. Sharpen cutting tool or select one that better suits the operation.</li> <li>3. Check for proper cutting rotation for cutting tool.</li> <li>4. Secure properly to the table.</li> <li>5. Fully retract spindle and lower headstock. This increases rigidity.</li> </ol>

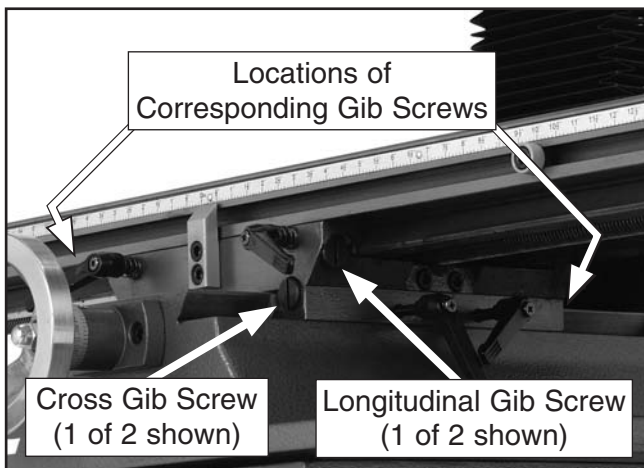


# Gibs

Gibs are wedge-shaped pieces of metal that fill the gap between the sliding surfaces of the machine. By adjusting the position of the gib in its gap, you can remove any play that might exist between the adjacent components. The gibs are pre-adjusted at the factory but due to storage, break-in, and usage, may require adjustment. If movement seems too tight at first, make sure that all the rust preventative that was shipped on the machine is removed from the ways. Lubricate the ways with oil, and work the table back-and-forth several times until the movement is easier.

## To adjust the table gibs:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Loosen the table travel locks (**Figure 54**).



**Figure 54.** Table gib adjustment screw locations.

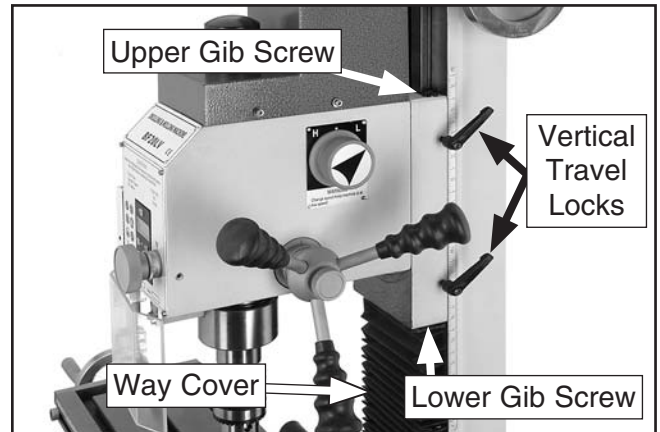
3. Loosen or tighten the front and rear gib screws (**Figure 54**) in an alternating manner to adjust the cross travel gib.

The table should slide smoothly in the cross direction with no play or looseness. Do not overtighten the gibs or premature slide and gib wear will occur.

4. Lubricate the cross way and gib.
5. Repeat the process for the longitudinal way gib using the gib adjustment screws on the left and right sides of the table base.

## To adjust the headstock gibs:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Remove the two screws that secure the top end of the way cover, pull it down to expose the lower gib screw, then loosen the vertical travel locks (**Figure 55**).



**Figure 55.** Headstock gib adjustment.

3. Loosen or tighten the upper and lower gib screws (**Figure 55**) in an alternating manner to adjust the headstock gib.

The headstock should slide smoothly with no play or looseness. Do not overtighten the gibs or premature slide and gib wear will occur.

4. Lubricate the headstock way and gib.
5. Re-install the way cover.



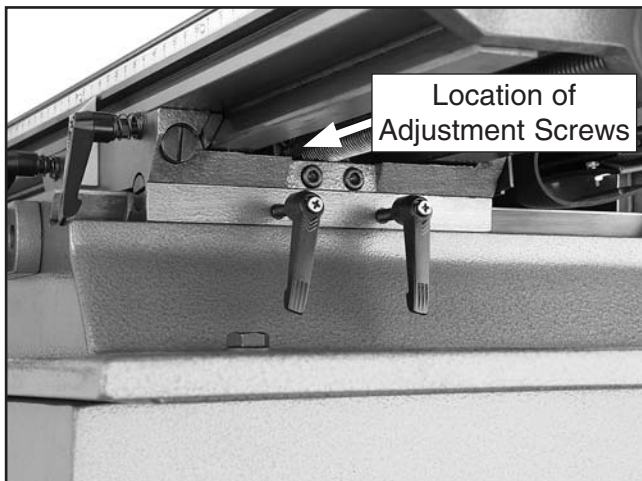
# Leadscrew Backlash

When you turn the handwheels to adjust the position of the table, you will notice slight play (backlash) in the handwheel before the table begins to move. If this play is greater than 0.008" (measured with the dial at the base of each handwheel), then you will need to adjust the leadscrew nuts.

To reach the adjustment screws on the leadscrew nut, you may have to fabricate extensions for your hex wrenches. When adjusting, make adjustments in small increments. Attempting to reduce backlash to less than 0.003" is impractical and will add unnecessary wear to both the leadscrews and the leadscrew nuts.

## To adjust the X-axis leadscrew:

1. Locate the X-axis leadscrew nut under the middle of the table. The head on the adjustment screws face to the right (**Figure 56**).



**Figure 56.** X-axis leadscrew adjusters.

2. Tighten the adjustment screws.
3. Test the adjustment by turning one of the longitudinal handwheels. The ideal amount of play when properly adjusted is 0.003"–0.006".

## To adjust the Y-axis leadscrew nut:

1. Locate the leadscrew nut underneath the table through the hole in the base under the rubber way cover.
2. Tighten the adjustment screws on the leadscrew nut in the same manner as described for the X-axis leadscrew adjustment.
3. Test the adjustment by turning one of the cross handwheels. The ideal amount of play when properly adjusted is 0.003"–0.006".

# Digital Readout Unit Battery Replacement

If the digital readout unit stops functioning, the battery must be replaced.

## To replace the digital readout unit battery:

1. Use a wide (#3) standard screwdriver or the edge of a coin to remove the battery cover (**Figure 57**).



**Figure 57.** Battery replacement.

2. Remove the old battery, dispose of it according to state and federal regulations, then replace it with a new one.
3. Replace the battery cover.



# Motor Service

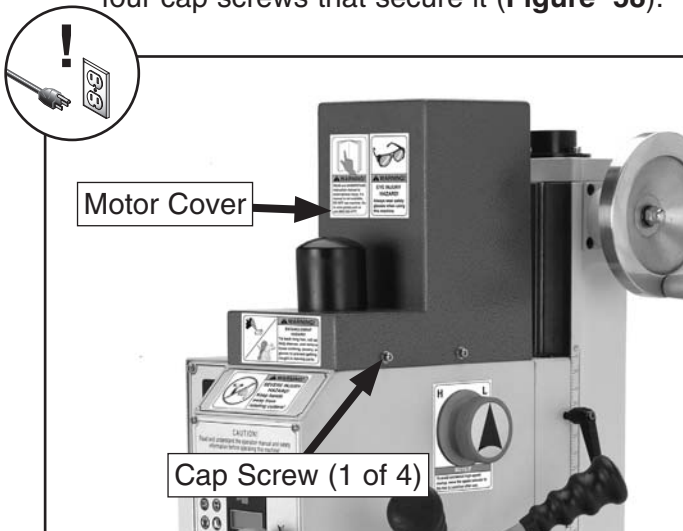
The bearings inside the motor are shielded and lubricated for the life of the bearing and require no routine maintenance.

This motor is equipped with long life carbon brushes. Brush life expectancy is affected by motor loading. Heavy motor loading will result in reduced brush life. If you notice a loss in power or if the motor becomes excessively noisy, inspect the brushes. If the brushes are worn down to 1/4" (6mm) or less, it is time to replace them. When checking brushes, be sure to return each brush to the same hole in the same direction that it came from. When replacing old brushes, replace both brushes at the same time.

Tools Needed:	Qty
Hex Wrench 3mm.....	1
Standard Screwdriver #2.....	1

## To inspect and replace the motor brushes:

1. DISCONNECT MILL/DRILL FROM POWER!
2. Un-install the motor cover by removing the four cap screws that secure it (**Figure 58**).



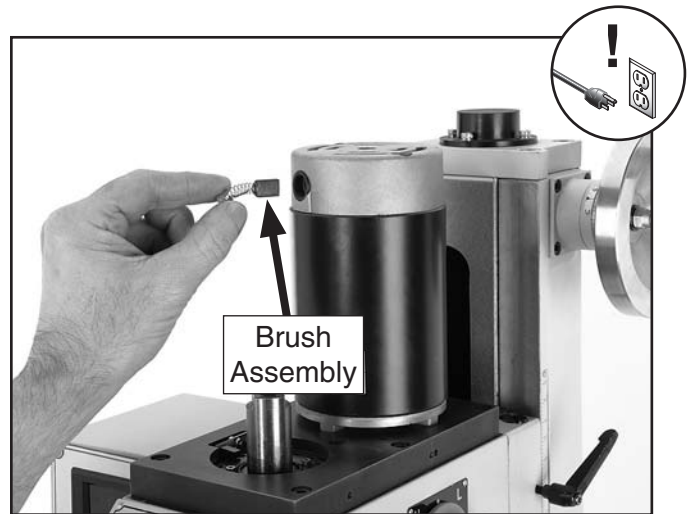
**Figure 58.** Removing motor cover.

3. Unscrew one of the brush caps to expose the brush assembly (**Figure 59**).



**Figure 59.** Removing brush cap.

4. Remove the old brush assembly. If the brush is worn down to less than 1/4" (6mm) then replace it with a new one. Otherwise re-install the brush (**Figure 60**).



**Figure 60.** Installing new brush assembly.

5. Replace the brush cap to secure the brush in place.
6. Repeat for second brush assembly on the other side of the motor.





# SECTION 8: WIRING

These pages are current at the time of printing. However, in the spirit of improvement, we may make changes to the electrical systems of future machines. Compare the manufacture date of your machine to the one stated in this manual, and study this section carefully.

If there are differences between your machine and what is shown in this section, call Technical Support at (570) 546-9663 for assistance BEFORE making any changes to the wiring on your machine. An updated wiring diagram may be available. **Note:** *Please gather the serial number and manufacture date of your machine before calling. This information can be found on the main machine label.*

## WARNING

### Wiring Safety Instructions

**SHOCK HAZARD.** Working on wiring that is connected to a power source is extremely dangerous. Touching electrified parts will result in personal injury including but not limited to severe burns, electrocution, or death. Disconnect the power from the machine before servicing electrical components!

**MODIFICATIONS.** Modifying the wiring beyond what is shown in the diagram may lead to unpredictable results, including serious injury or fire. This includes the installation of unapproved after-market parts.

**WIRE CONNECTIONS.** All connections must be tight to prevent wires from loosening during machine operation. Double-check all wires disconnected or connected during any wiring task to ensure tight connections.

**CIRCUIT REQUIREMENTS.** You MUST follow the requirements at the beginning of this manual when connecting your machine to a power source.

**WIRE/COMPONENT DAMAGE.** Damaged wires or components increase the risk of serious personal injury, fire, or machine damage. If you notice that any wires or components are damaged while performing a wiring task, replace those wires or components.

**MOTOR WIRING.** The motor wiring shown in these diagrams is current at the time of printing but may not match your machine. If you find this to be the case, use the wiring diagram inside the motor junction box.
















**CAPACITORS/INVERTERS.** Some capacitors and power inverters store an electrical charge for up to 10 minutes after being disconnected from the power source. To reduce the risk of being shocked, wait at least this long before working on capacitors.

**EXPERIENCING DIFFICULTIES.** If you are experiencing difficulties understanding the information included in this section, contact our Technical Support at (570) 546-9663.

#### NOTICE

The photos and diagrams included in this section are best viewed in color. You can view these pages in color at [www.grizzly.com](http://www.grizzly.com).

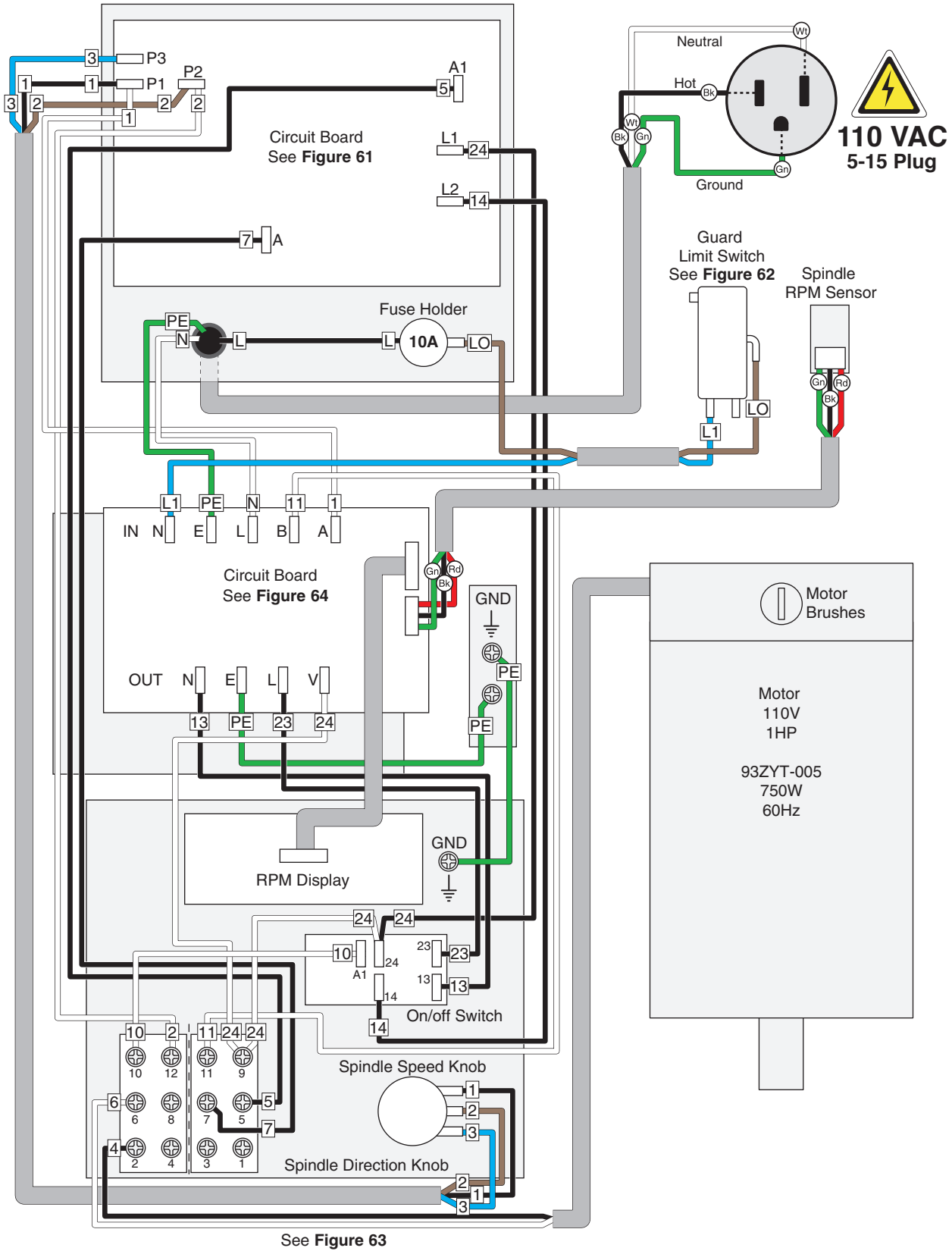
#### COLOR KEY

BLACK 	BLUE 	YELLOW 	LIGHT BLUE 
WHITE 	BROWN 	YELLOW GREEN 	BLUE WHITE 
GREEN 	GRAY 	PURPLE 	TURQUOISE 
RED 	ORANGE 	PINK 	





# Wiring Diagram



# Electrical Components



Figure 61. Rear panel.

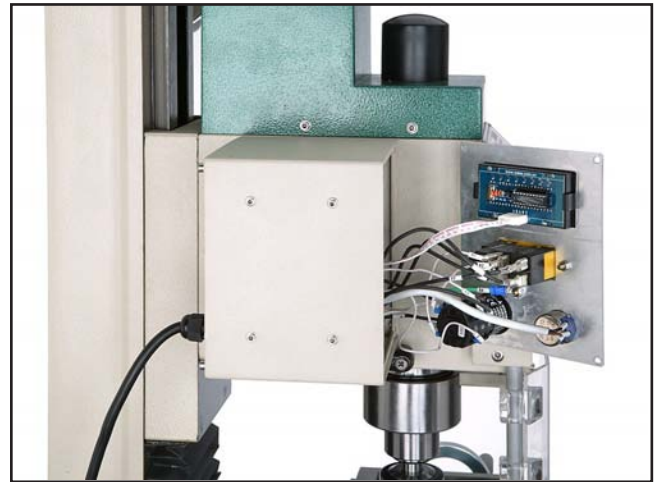


Figure 63. Control panel wiring.



Figure 62. Chip guard limit switch.

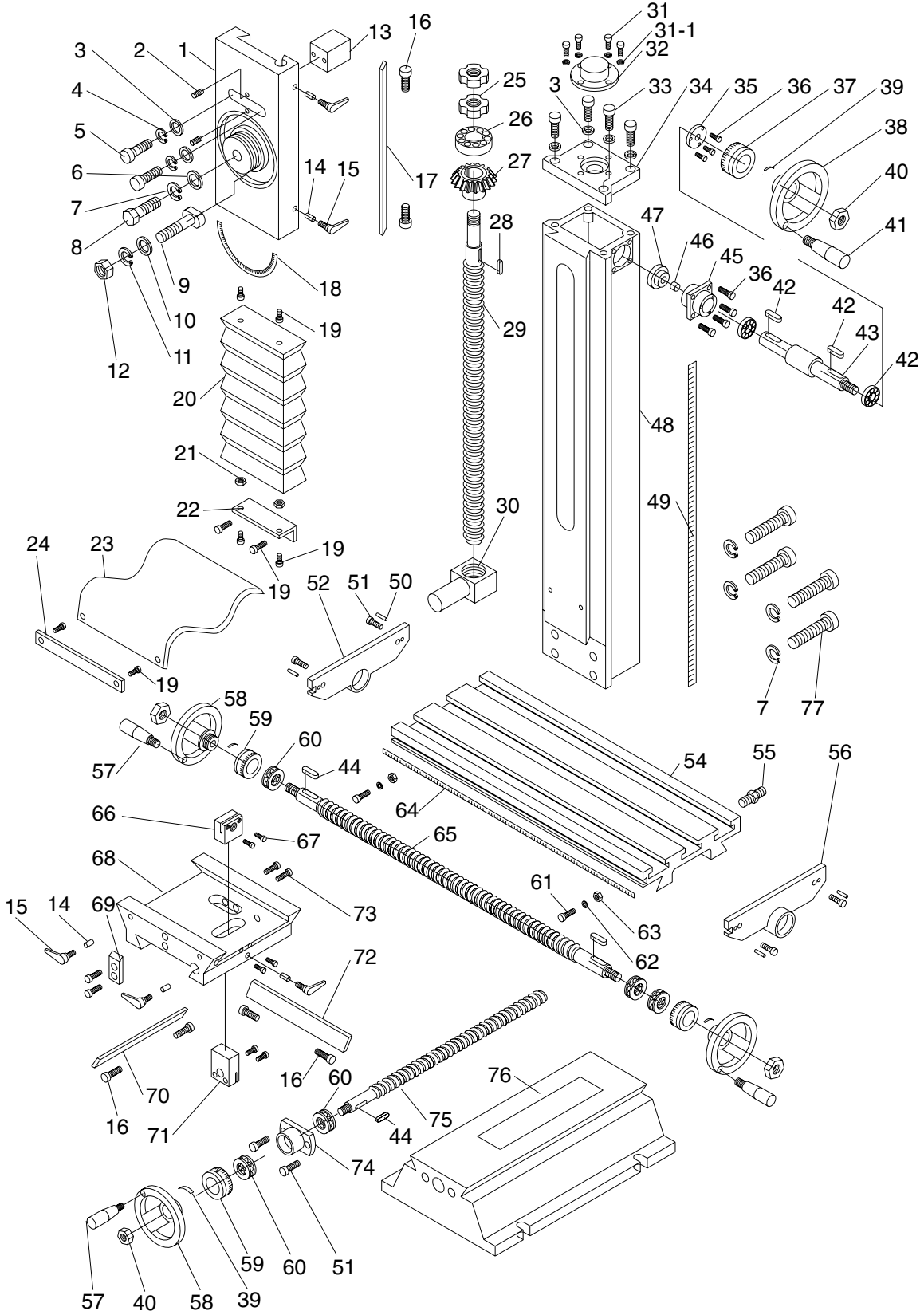


Figure 64. Side panel.



# SECTION 9: PARTS

## Column Breakdown



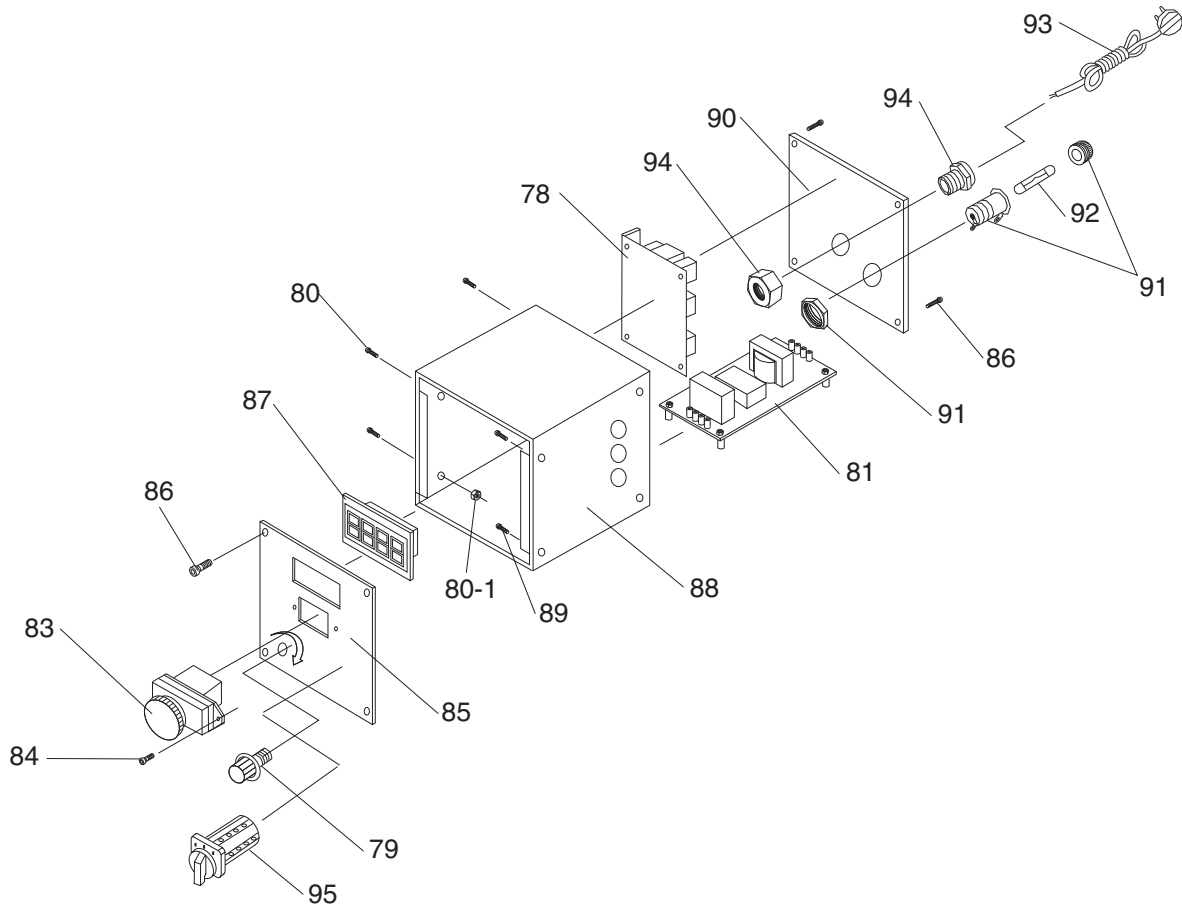
# Column Parts List

REF	PART #	DESCRIPTION
1	P0704001	VERTICAL SLIDE
2	PSS11M	SET SCREW M6-1 X 16
3	PW01M	FLAT WASHER 8MM
4	PLW04M	LOCK WASHER 8MM
5	PCAP31M	CAP SCREW M8-1.25 X 25
6	PW06M	FLAT WASHER 12MM
7	PLW05M	LOCK WASHER 12MM
8	PCAP92M	CAP SCREW M12-1.75 X 40
9	P0704009	T-BOLT M10-1.5
10	PW04M	FLAT WASHER 10MM
11	PLW06M	LOCK WASHER 10MM
12	PN02M	HEX NUT M10-1.5
13	P0704013	BLOCK
14	P0704014	BRASS PIN
15	P0704015	LOCK LEVER
16	P0704016	GIB SCREW
17	P0704017	VERTICAL GIB
18	P0704018	ANGLE SCALE
19	PCAP50M	CAP SCREW M5-.8 X 10
20	P0704020	DUST COVER
21	PN06M	HEX NUT M5-.8
22	P0704022	DUST COVER BRACKET
23	P0704023	CROSS WAY COVER
24	P0704024	CROSS WAY COVER BRACKET
25	P0704025	LEADSCREW LOCK NUT M16-2
26	P51203	THRUST BEARING 51203
27	P0704027	RING GEAR
28	PK37M	KEY 4 X 4 X 16
29	P0704029	VERTICAL LEADSCREW
30	P0704030	VERTICAL LEADSCREW NUT
31	PCAP33M	CAP SCREW M5-.8 X 12
31-1	PW02M	FLAT WASHER 5MM
32	P0704032	BEARING COVER
33	PCAP14M	CAP SCREW M8-1.25 X 20
34	P0704034	COLUMN TOP PLATE
35	P0704035	COLLAR FLANGE
36	PCAP33M	CAP SCREW M5-.8 X 12
37	P0704037	DIAL COLLAR
38	P0704038	VERTICAL HANDWHEEL

REF	PART #	DESCRIPTION
39	P0704039	COLLAR INDICATOR
40	PN03M	HEX NUT M8-1.25
41	P0704041	VERTICAL HANDWHEEL HANDLE
42	P6001ZZ	BALL BEARING 6001ZZ
43	P0704043	VERTICAL HANDWHEEL SHAFT
44	PK69M	KEY 4 X 4 X 12
45	P0704045	PILLOW BLOCK
46	P0704046	SPACER
47	P0704047	PINION GEAR
48	P0704048	COLUMN
49	P0704049	COLUMN SCALE
50	PRP52M	THREADED SLEEVE
51	PCAP27M	CAP SCREW M6-1 X 14
52	P0704052	LEFT TABLE ENDPLATE
54	P0704054	TABLE
55	P0704055	COOLANT DRAIN FITTING
56	P0704056	RIGHT TABLE ENDPLATE
57	P0704057	TABLE HANDWHEEL HANDLE
58	P0704058	TABLE HANDWHEEL
59	P0704059	TABLE HANDWHEEL COLLAR
60	P51200	THRUST BEARING 51200
61	PCAP04M	CAP SCREW M6-1 X 10
62	P0704062	TABLE STOP
63	P0704063	T-NUT M6-1
64	P0704064	TABLE SCALE
65	P0704065	LONGITUDINAL LEADSCREW
66	P0704066	LONGITUDINAL HALF NUT
67	PCAP39M	CAP SCREW M4-.7 X 20
68	P0704068	CROSS SLIDE
69	P0704069	CENTER STOP BLOCK
70	P0704070	CROSS GIB
71	P0704071	CROSS HALF NUT
72	P0704072	LONGITUDINAL GIB
73	PCAP06M	CAP SCREW M6-1 X 25
74	P0704074	CROSS BEARING BLOCK
75	P0704075	CROSS LEADSCREW
76	P0704076	BASE
77	PCAP101M	CAP SCREW M12-1.75 X 90



# Electrical Box Breakdown & Parts List

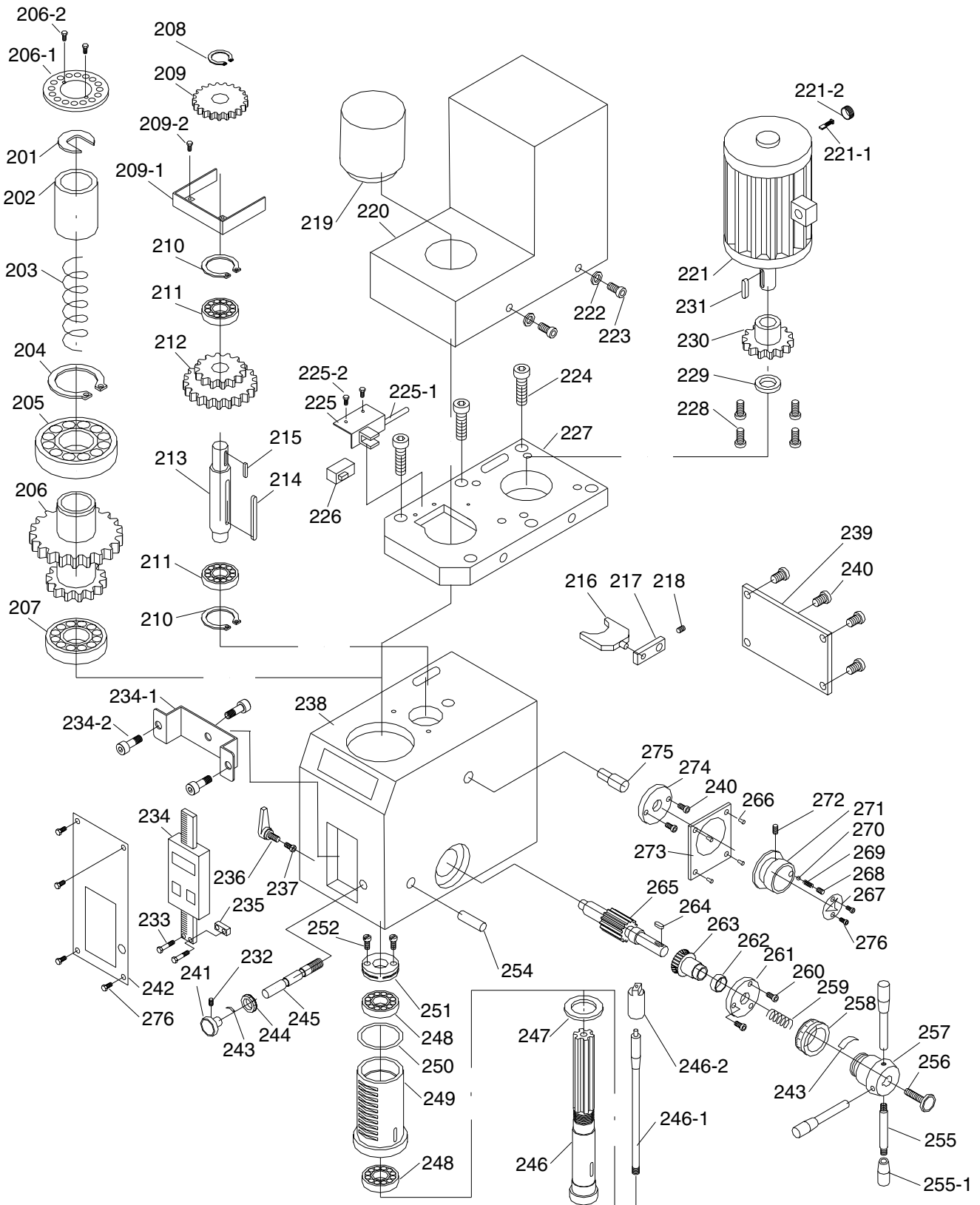


REF	PART #	DESCRIPTION
78	P0704078	SPEED CONTROL CIRCUIT BOARD
79	P0704079	VARIABLE SPEED KNOB
80	PCAP158M	CAP SCREW M3-.5 X 16
80-1	PN07M	HEX NUT M3-.5
81	P0704081	MAIN CIRCUIT BOARD
83	P0704083	ON/OFF SWITCH
84	PCAP17M	CAP SCREW M4-.7 X 10
85	P0704085	CONTROL PANEL
86	PCAP110M	CAP SCREW M4-.7 X 6

REF	PART #	DESCRIPTION
87	P0704087	SPINDLE RPM READOUT
88	P0704088	ELECTRICAL BOX
89	PCAP03M	CAP SCREW M5-.8 X 8
90	P0704090	ELECTRICAL BOX COVER
91	P0704091	FUSE HOLDER
92	P0704092	FUSE 10A
93	P0704093	POWER CORD 18AWG X 3C X 72"L
94	P0704094	STRAIN RELIEF
95	P0704095	FWD/REV SWITCH



# Headstock Breakdown





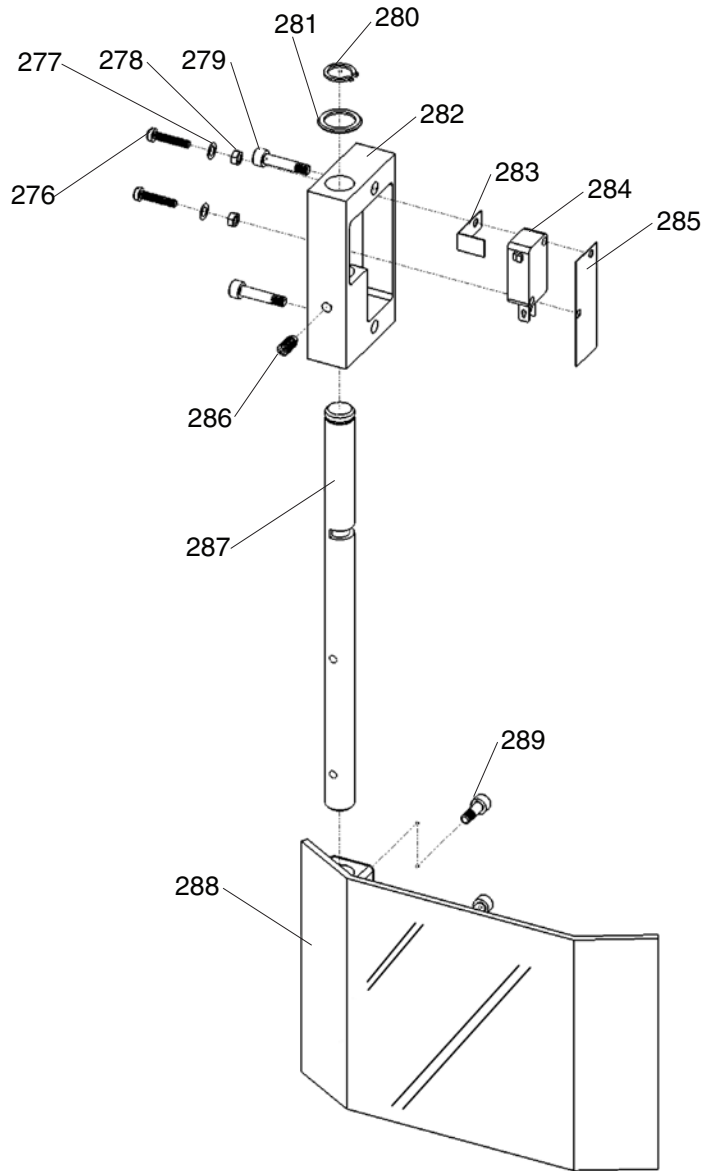
# Headstock Parts List

REF	PART #	DESCRIPTION
201	P0704201	QUILL RETANING CLIP
202	P0704202	BUSHING
203	P0704203	COMPRESSION SPRING
204	PR56M	EXT RETAINING RING 45MM
205	P6209ZZ	BALL BEARING 6209ZZ
206	P0704206	GEARS 60/70T
206-1	P0704206-1	SPINDLE RING 16MM
206-2	PCAP80M	CAP SCREW M3-.5 X 8
207	P7007-OPEN	BALL BEARING 7007-OPEN
208	PR05M	EXT RETAINING RING 15MM
209	P0704209	GEAR 37T
209-1	P0704209-1	GUARD
209-2	PCAP57M	CAP SCREW M3-.5 X 6
210	PR37M	EXT RETAINING RING 32MM
211	P6002ZZ	BALL BEARING 6002ZZ
212	P0704212	GEAR 42/62T
213	P0704213	SHAFT
214	PK36M	KEY 5 X 5 X 50
215	PK10M	KEY 5 X 5 X 12
216	P0704216	FORK
217	P0704217	FORK ARM
218	PSS31M	SET SCREW M5-.8 X 8
219	P0704219	DRAWBAR CAP
220	P0704220	MOTOR COVER
221	P0704221	MOTOR 110V 1HP 1-PH
221-1	P0704221-1	BRUSH ASSEMBLY
221-2	P0704221-2	BRUSH CAP
222	PW05M	FLAT WASHER 4MM
223	PCAP18M	CAP SCREW M4-.7 X 8
224	PCAP27M	CAP SCREW M6-1 X 14
225	P0704225	SENSOR BRACKET
225-1	P0704225-1	SENSOR CORD
225-2	PCAP57M	CAP SCREW M3-.5 X 6
226	P0704226	RPM SENSOR
227	P0704227	MOTOR PLATE
228	PCAP33M	CAP SCREW M5-.8 X 12
229	P0704229	MOTOR GEAR RING
230	P0704230	GEAR 25T
231	PK72M	KEY 4 X 4 X 6
232	PSS26M	SET SCREW M5-.8 X 6
233	PCAP57M	CAP SCREW M3-.5 X 6
234	P0704234	DIGITAL READOUT UNIT
234-1	P0704234-1	DIGITAL READOUT BRACKET
234-2	PCAP17M	CAP SCREW M4-.7 X 10

REF	PART #	DESCRIPTION
235	P0704235	BASE BLOCK
236	P0704236	QUILL LOCKING LEVER
237	P0704237	BRASS PIN
238	P0704238	MILL HEAD CASTING
239	P0704239	COVER PLATE
240	PCAP18M	CAP SCREW M4-.7 X 8
241	P0704241	FINE FEED KNOB
242	PSS26M	FRONT COVER
243	P0704243	COLLAR INDICATOR
244	P0704244	FINE FEED COLLAR
245	P0704245	WORM SHAFT
246	P0704246	SPINDLE
246-1	P0704246-1	DRAWBAR
246-2	P0704246-2	RETAINER CUP
247	P0704247	SPINDLE RING
248	P32005	TAPERED ROLLER BEARING 32005
249	P0704249	QUILL SLEEVE
250	P0704250	RUBBER RING
251	P0704251	ADJUSTER NUT
252	P0704252	ADJUSTER NUT SCREW
254	P0704254	PIN 6 X 30
255	P0704255	HANDLE
255-1	P0704255-1	HANDLE GRIP
256	P0704256	SELECTOR KNOB
257	P0704257	DOWNFEED HUB
258	P0704258	DOWNFEED COLLAR
259	P0704259	COMPRESSION SPRING
260	PCAP46M	CAP SCREW M4-.7 X 40
261	P0704261	DOWNFEED FLANGE
262	P0704262	SPACER
263	P0704263	WORM GEAR
264	PK69M	KEY 4 X 4 X 12
265	P0704265	GEAR SHAFT
266	P0704266	RIVET
267	P0704267	HIGH/LOW ARROW PLATE
268	PSS20M	SET SCREW M8-1.25 X 8
269	P0704269	COMPRESSION SPRING
270	PSTB004M	STEEL BALL 6.5MM
271	P0704271	SPEED SELECTOR KNOB
272	PSS34M	SET SCREW M5-.8 X 16
273	P0704273	SPEED KNOB PLATE
274	P0704274	FORK SHAFT FLANGE
275	P0704275	FORK SHAFT
276	PCAP158M	CAP SCREW M3-.5 X 16



# Chip Guard Breakdown & Parts List



REF	PART #	DESCRIPTION
276	PCAP158M	CAP SCREW M3-.5 X 16
277	PW07M	FLAT WASHER 3MM
278	PN07M	HEX NUT M3-.5
279	PCAP39M	CAP SCREW M4-.7 X 20
280	PR03M	EXT RETAINING RING 12MM
281	P0704281	WAVY WASHER 20MM
282	P0704282	GUARD MOUNTING BLOCK

REF	PART #	DESCRIPTION
283	P0704283	COPPER SPACER
284	P0704284	GUARD LIMIT SWITCH
285	P0704285	PROTECTIVE PAPER
286	PSS05M	SET SCREW M5-.8 X 10
287	P0704287	CHIP GUARD POST
288	P0704288	CHIP GUARD
289	PCAP51M	CAP SCREW M4-.7 X 18



# Labels Breakdown & Parts List



REF	PART #	DESCRIPTION
301	PLABEL-12C	READ MANUAL LABEL
302	PLABEL-11B	SAFETY GLASSES LABEL
303	P0704303	MACHINE ID LABEL
304	P0704304	HIGH/LOW SPEED LABEL
305	PPAINT-11	PUTTY TOUCH-UP PAINT

REF	PART #	DESCRIPTION
306	P0704306	MODEL NUMBER LABEL
307	PPAINT-1	GREEN TOUCH-UP PAINT
308	P0704308	CUTTER WARNING LABEL
309	PLABEL-55C	ENTANGLEMENT LABEL

## WARNING

Safety labels warn about machine hazards and ways to prevent injury. The owner of this machine **MUST** maintain the original location and readability of the labels on the machine. If any label is removed or becomes unreadable, **REPLACE** that label before using the machine again. Contact Grizzly at (800) 523-4777 or [www.grizzly.com](http://www.grizzly.com) to order new labels.



# NOTES





# WARRANTY CARD

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<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Handy	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Live Steam	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Shotgun News	
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Today's Homeowner	
<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Wood	
  
3. What is your annual household income?
 

<input type="checkbox"/> \$20,000-\$29,000	<input type="checkbox"/> \$30,000-\$39,000	<input type="checkbox"/> \$40,000-\$49,000
<input type="checkbox"/> \$50,000-\$59,000	<input type="checkbox"/> \$60,000-\$69,000	<input type="checkbox"/> \$70,000+
  
4. What is your age group?
 

<input type="checkbox"/> 20-29	<input type="checkbox"/> 30-39	<input type="checkbox"/> 40-49
<input type="checkbox"/> 50-59	<input type="checkbox"/> 60-69	<input type="checkbox"/> 70+
  
5. How long have you been a woodworker/metalworker?
 

<input type="checkbox"/> 0-2 Years	<input type="checkbox"/> 2-8 Years	<input type="checkbox"/> 8-20 Years	<input type="checkbox"/> 20+ Years
------------------------------------	------------------------------------	-------------------------------------	------------------------------------
  
6. How many of your machines or tools are Grizzly?
 

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------------------------------	------------------------------	------------------------------	------------------------------
  
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# WARRANTY AND RETURNS

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Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

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